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St. Louis, Missouri 63166

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Technology Insertion (TI)/Industrial Process Improvement (IPI) Data Base Documentation Book Volume, for OC-ALC/MATPCA (Electrical Accessories). This document contains detailed information about layouts equipment and processes for this RCC.

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TECHNOLOGY INSERTION-ENGINEERING SERVICES
PROCESS CHARACTERIZATION
TASK ORDER NO. 1
(BLOCK II)

DATABASE DOCUMENTATION BOOK

OC-ALC

MATPCA

A-1 23

CONTRACT SUMMARY REPORT
11 SEPTEMBER 1989

CONTRACT NO. F33600-88-D-0567
CDRL SEQUENCE NO. B008

MCDONNELL DOUGLAS
McDonnell Douglas Missile Systems Company
St. Louis, Missouri 63166-0516 (314) 232-0232

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TABLE OF CONTENTS

1.0 IDENTIFICATION OF RCC

MATPCA is separated into two sections, each having its own workload and personnel. The two sections are physically separated by an eight foot isle which runs between them. The two sections share storage cabinets and some test equipment, but otherwise exist as separate entities, each having its own supervisor. Workloads appear to be divided equitably based on existing staffing.

The first section's workload consists mostly of ignition exciters, temp. probes, electrically actuated valves, and associated electrical accessories. The work area is somewhat crowded with test equipment and work benches, much of which is not being utilized due to the present workload levels. The existing facilities would be capable of processing a much greater workload given the needed staffing. This section contains 6,250 square feet of floor space.

The second section's workload is mostly made up of temperature amplifiers, servo-motors, and power supllies. Again, the area contains several benches and and testing equipment which is not being utilized at their full potential given the present workload. The section contains 2,875 square feet of floor space.

Note that MISTR items are normally delivered to an outside storage area in building 3123. Technicians normally are sent to this area once a week to uncrate accessories and load them onto a transport trailer.

2.0 GENERAL INFORMATION

MATPCA is an electrical accessories repair unit within the Accessories Division Production Branch at OC-ALC. This RCC is located in building 3001.

The primary responsibility of MATPCA is to overhaul, repair, and bench test motors, exciters, power supplies, servo-motors, and a variety of aircraft and engine electrical accessories. The primary workload in this RCC consists of MISTR and PDM items, with the PDM accessories being worked mainly as support for the engine overhaul unit at OC-ALC.

The workload of MATPCA has been relatively stable for the last several years, but it should be mentioned that production levels for recent months has been lower due to decreasing demand for certain aircraft parts. MATPCA has historically worked electrical accessory parts for the A-7, F-4, and B-52 aircraft. As these aircraft are phased out of the active Air Force inventory, demand for overhaul and repair work has decreased. We may expect to see production levels increase as new electrical accessories from aircraft such as the F-16 and B-1 enter the depot system. It must be emphasized that MATPCA is in a transition period between the old and new aircraft technologies, and that a definitive workload analysis would need to account for the changing patterns of processed parts.

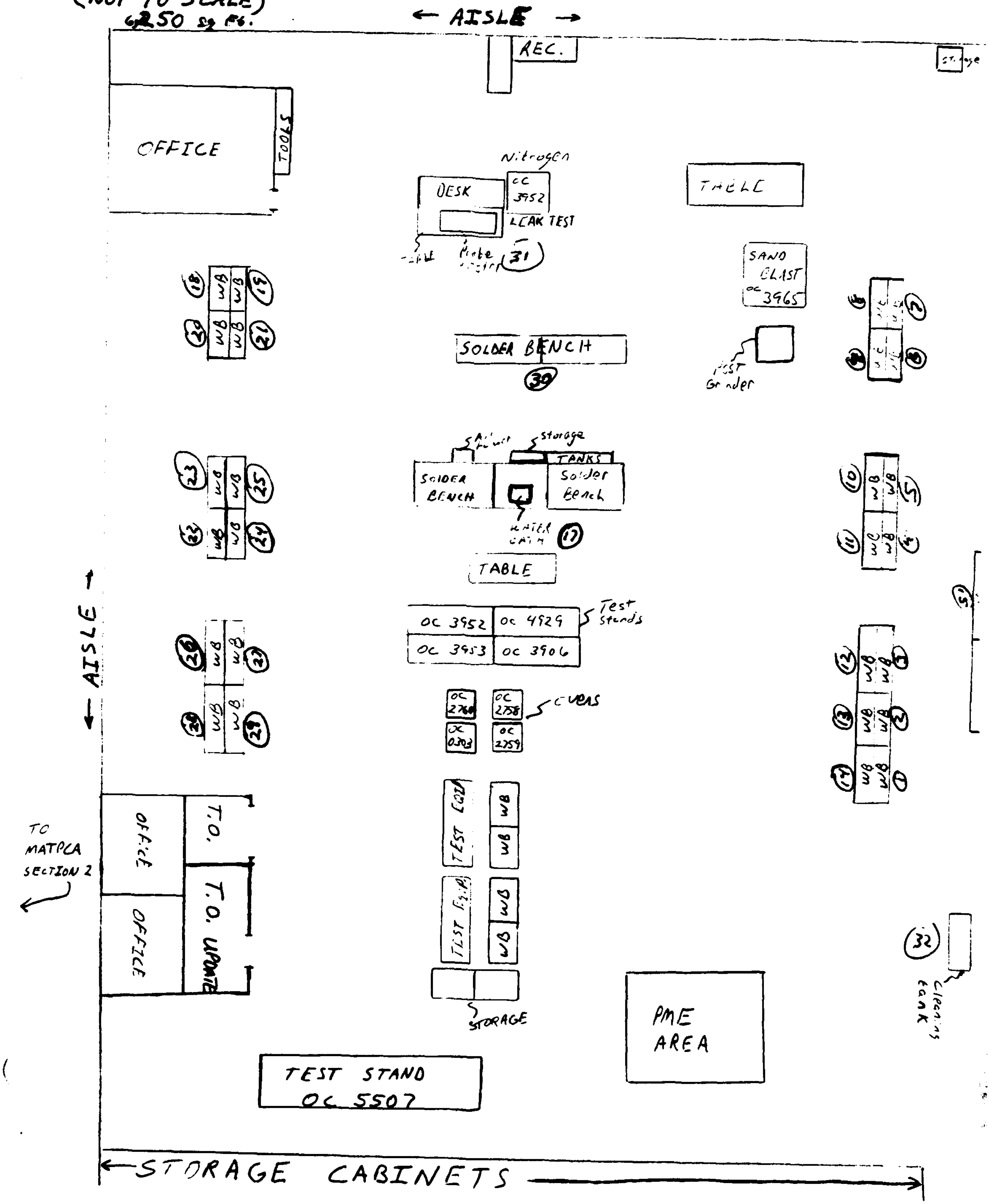
2.1 FACILITY LAYOUT DRAWING

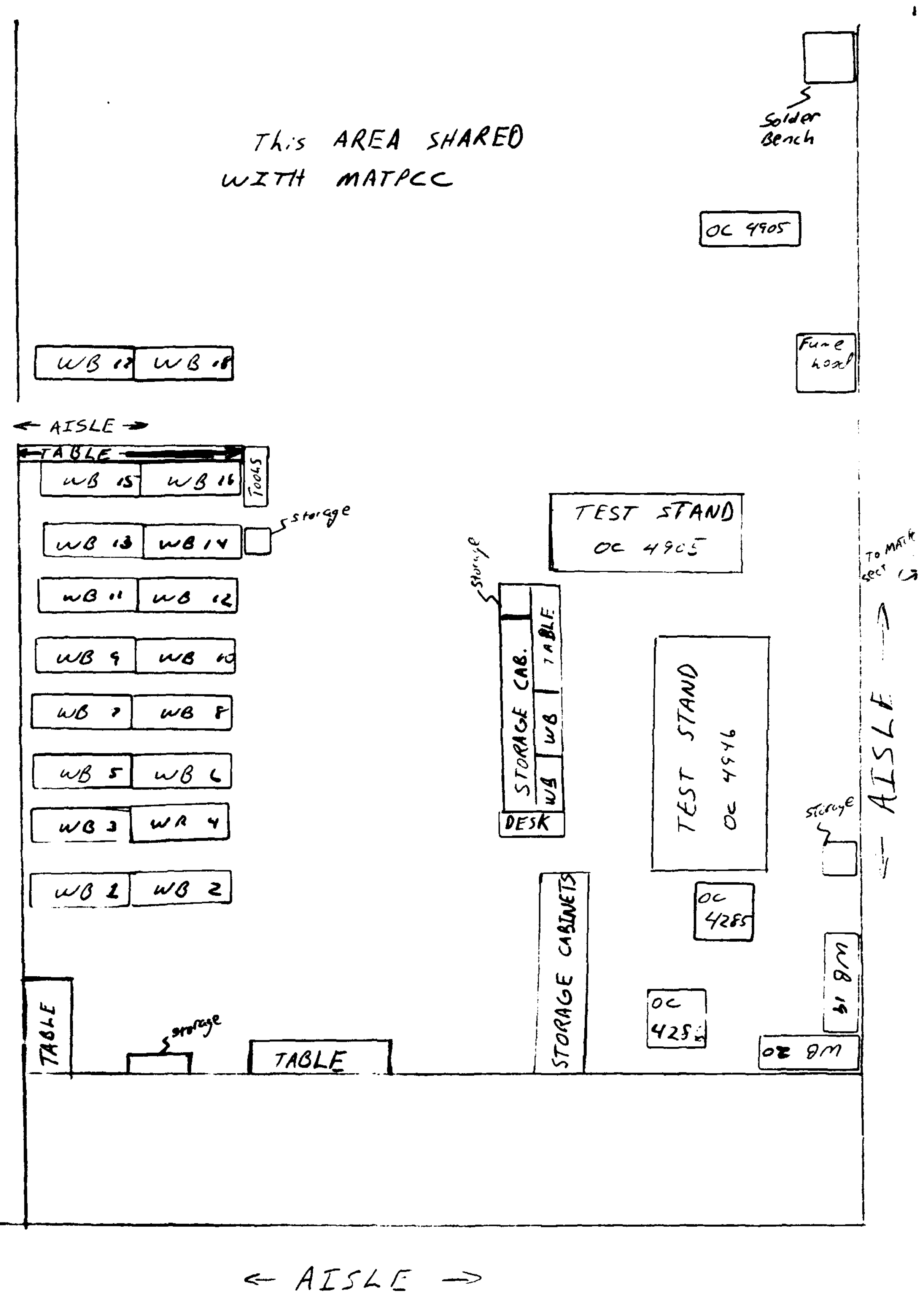
The existing facility layout drawings are not representative of the present conditions. There have been changes to the shop floor as well as a restructuring of the MATPCA RCC. The attached layouts are representative of the present conditions.

2.7A MATPCA SECTION 1

(NOT TO SCALE)

6250 sq ft.





2.7B MATPCA
SECTION 2
(NOT TO SCALE)

2,875 sq ft.

2.2 EQUIPMENT

Equipment presently used in the MATPCA RCC consists of a variety of electrical test stands, common electrical testing equipment such as oscilloscope, ohmmeters, meggers, etc., and both common and specialized hand tools.

The test stands used in this RCC range from four to thirty years old, with much of the equipment being at least twenty years old. It is somewhat surprising that newer equipment purchased in the last five years to support repair and testing of B-1 and F-16 electrical accessories shows a much higher rate of downtime and repair requests than does the older equipment.

A detailed listing of the equipment used in MATPCA is included in the equipment profile, which is enclosed in this report.

2.3 WORKFORCE

MATPCA has a relatively stable workforce with little variance. Workloads are well defined and personnel appear knowledgeable about their tasks. The workforce is comprised of two supervisors, 32 journeyman technicians, a sandblast technician, and a painter. The following is a breakdown of the manpower in the MATPCA RCC.

SKILL CODE	SKILL LEVEL	QUANTITY	EXPERIENCE
AY	WG-10	5	12
	WG-9	6	8
BY	WG-10	10	7
	WG-9	10	4
	WG-7	2	6
B3	WG-7	1	2

Experience is given as average years at that grade. Note that MATPCA is supported by two backshops, MATPCM machine shop and MATPIW welding shop.

2.4 REPAIR PROCESS TECHNOLOGIES

The repair process technology in MATPCA consists of testing and repair of aircraft and aircraft engine electrical accessories.

Accessories are tested for function and specification requirements, and overhaul is performed as required. Modifications are made to existing items as required be tech order changes and to meet the present configuration required for targeted aircraft.

When applicable, repairs are made to internal components of the worked accessories, as well testing,

replacement of defective parts, and inspection of problems requiring backshop support.

2.5 WORKLOAD VOLUME AND MIX

The workload within MATPCA consists of both MISTR and PDM. Electrical accessories sent to the engine overhaul facility at OC-ALC is a PDM workload. All other items tested and/or overhauled are MISTR designated.

Workloads are variable and depend on Air Force inventory needs. For more information see the enclosed workload profile.

2.6 MATERIAL HANDLING

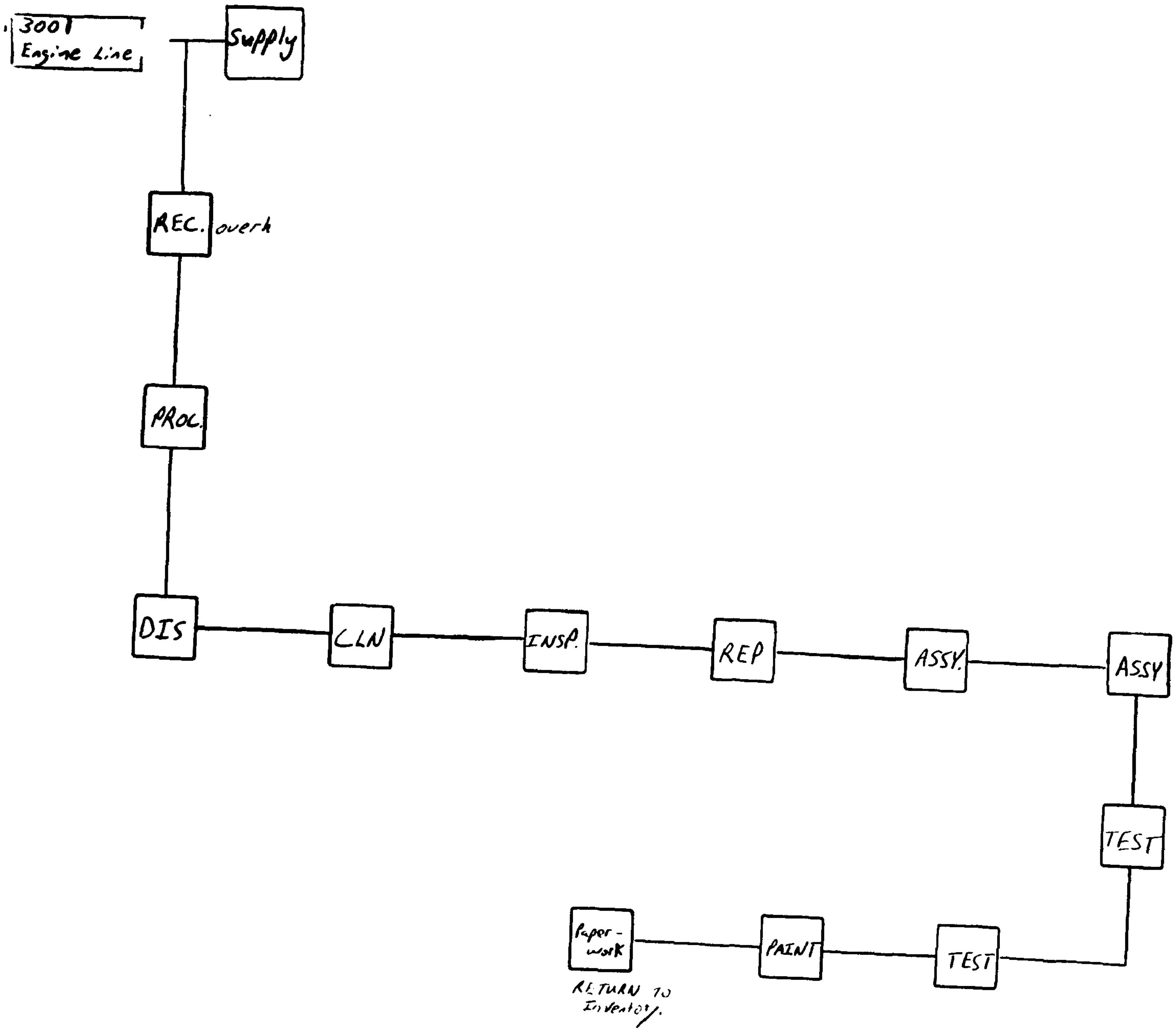
Material handling in MATPCA is mostly by hand. Material is initially received in building 3123. Technicians are sent to this area to uncrate received items and place them on a specially suspended trailer. A tug driver is then called to move the items to Bld. 3001 where they are placed in storage cabinets. This procedure is normally performed once a week and requires approximately four hours of the skilled technician's time.

2.7 STORAGE

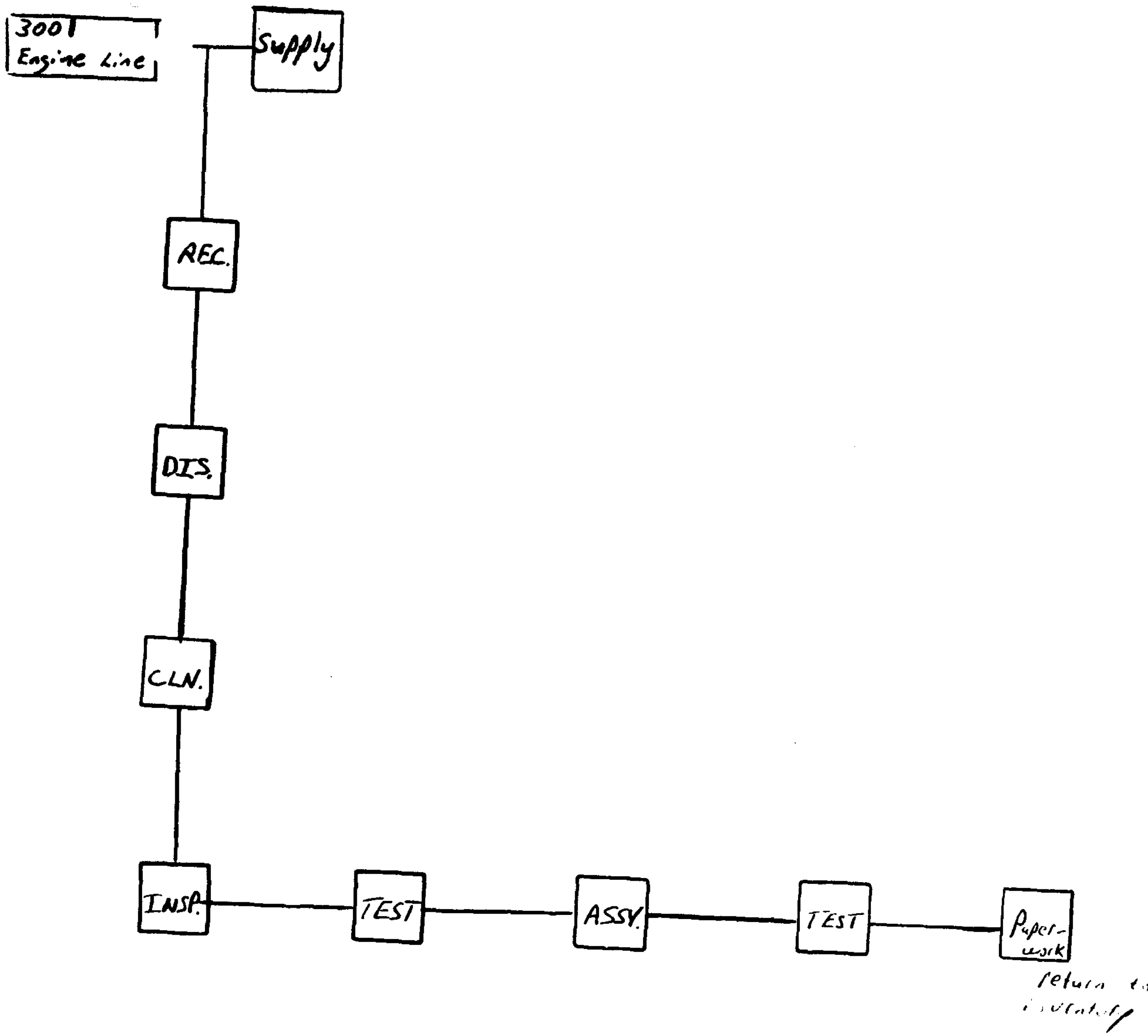
Storage in the MATPCA area consists of 76 cabinets that are 6x3x2 feet in size. These cabinets are located throughout the MATPCA shop area as shown on the facility layout drawing enclosed.

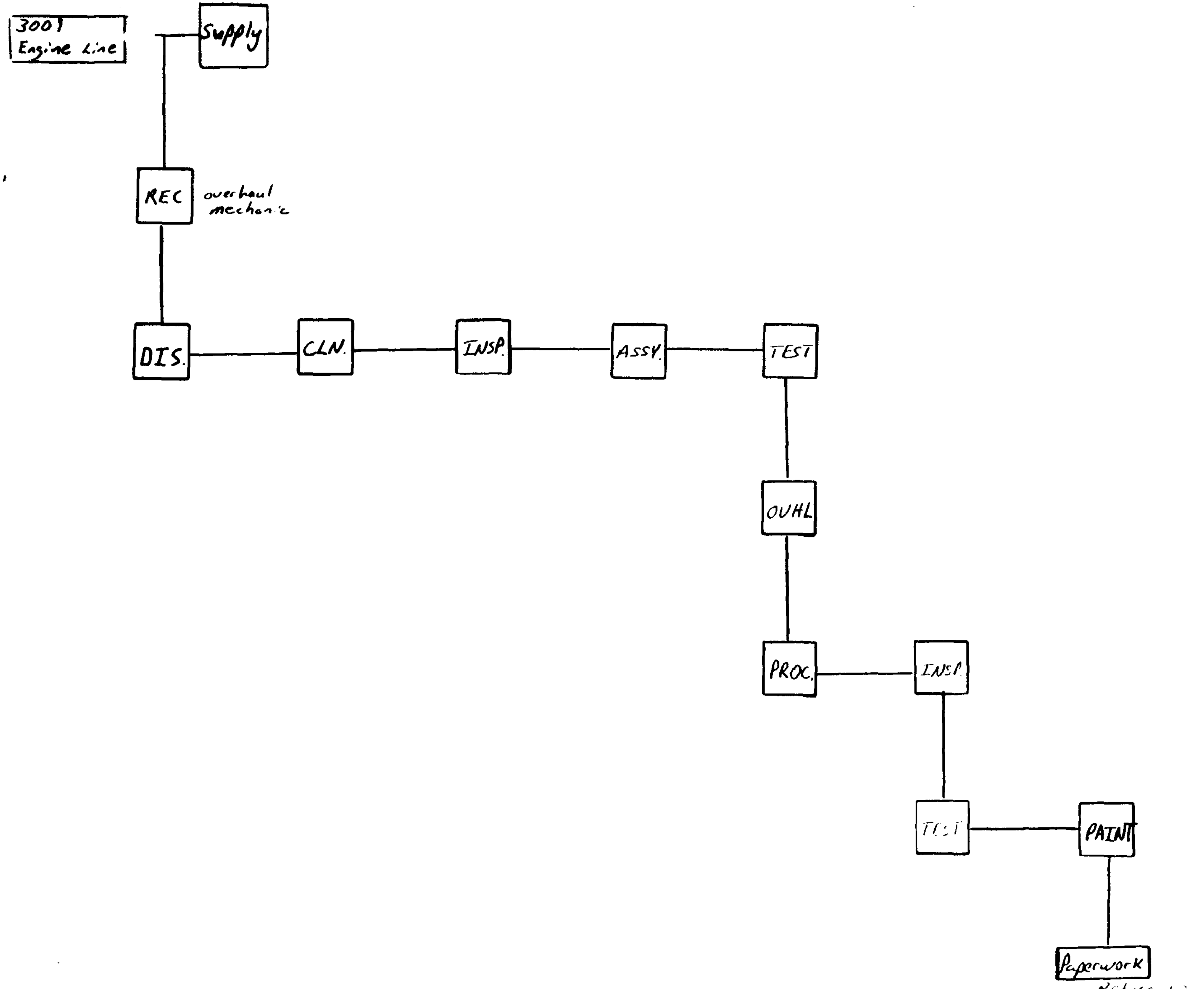
2.8 PROCESS FLOW DIAGRAMS

The following process flow diagrams are representative of the operations required to test and/or overhaul the various items worked by the MATPCA Accessories RCC. The items have been divided into family groups (i.e., like items in regard to designation and function). Operations shown often represent a logical combination of similar and related tasks. For more detailed analysis of the processes studied, please refer to the appropriate operation profile packet (enclosed).

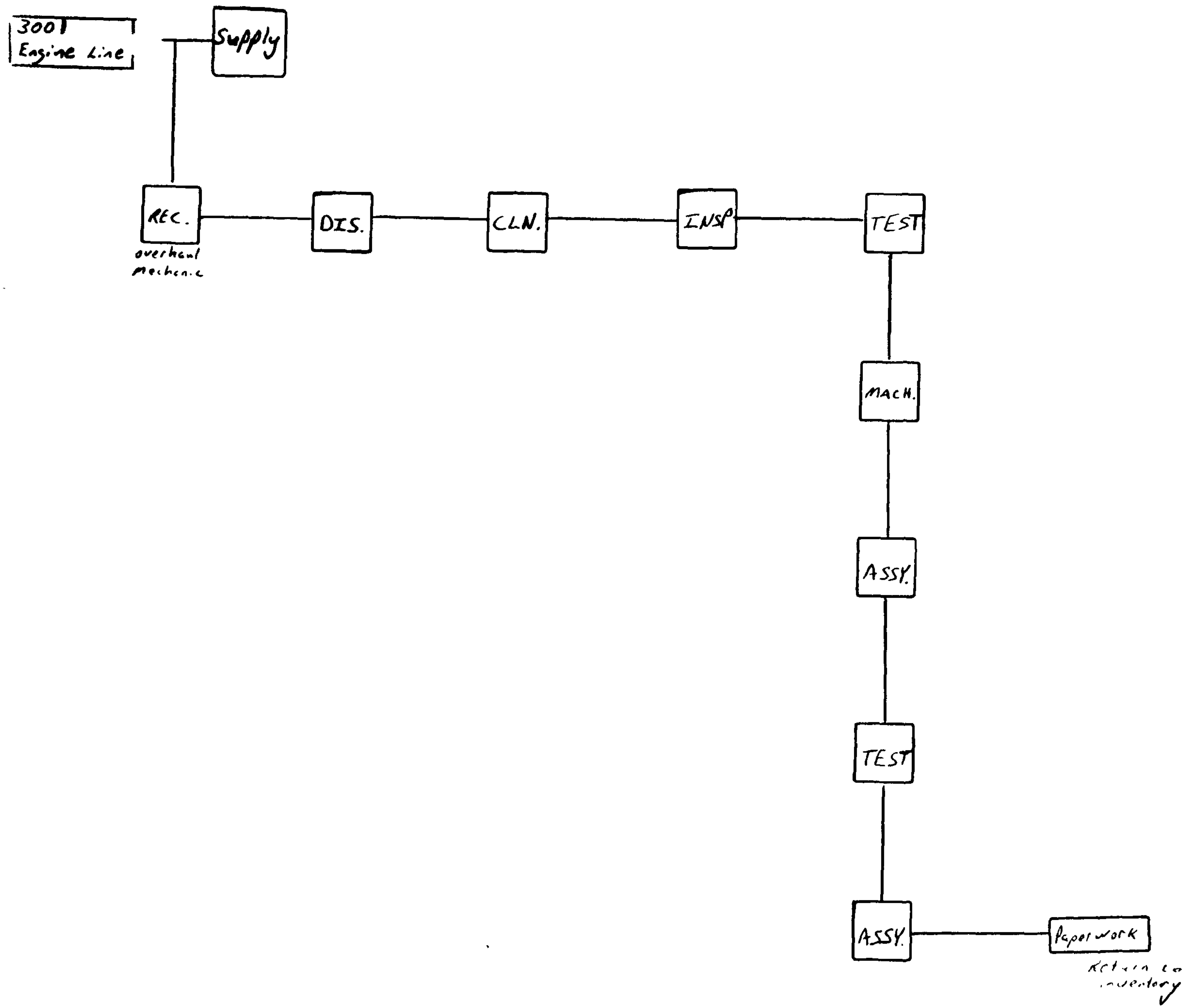


[illegible] Control Relay Box

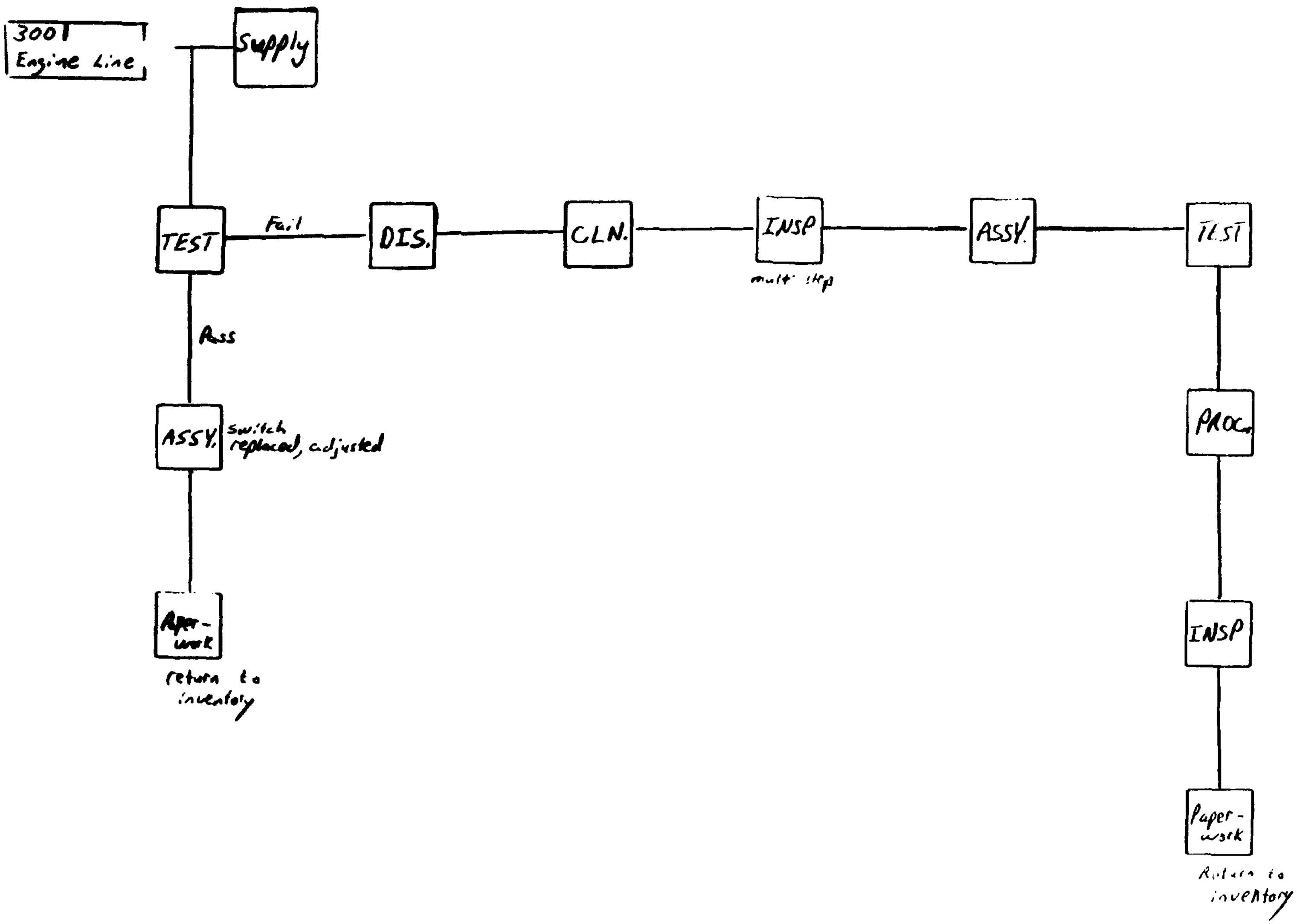

3001
Engine Line
Supply
REC.
DIS.
CLN.
INSP.
TEST
ASSY.
TEST
Paper-
work
return to
inventory


300T
Engine Line
Supply
REC
overhaul
mechanic
DIS.
CLN.
INSP.
ASSY.
TEST
OVHL
PROC.
INSP.
PAINT
Paperwork

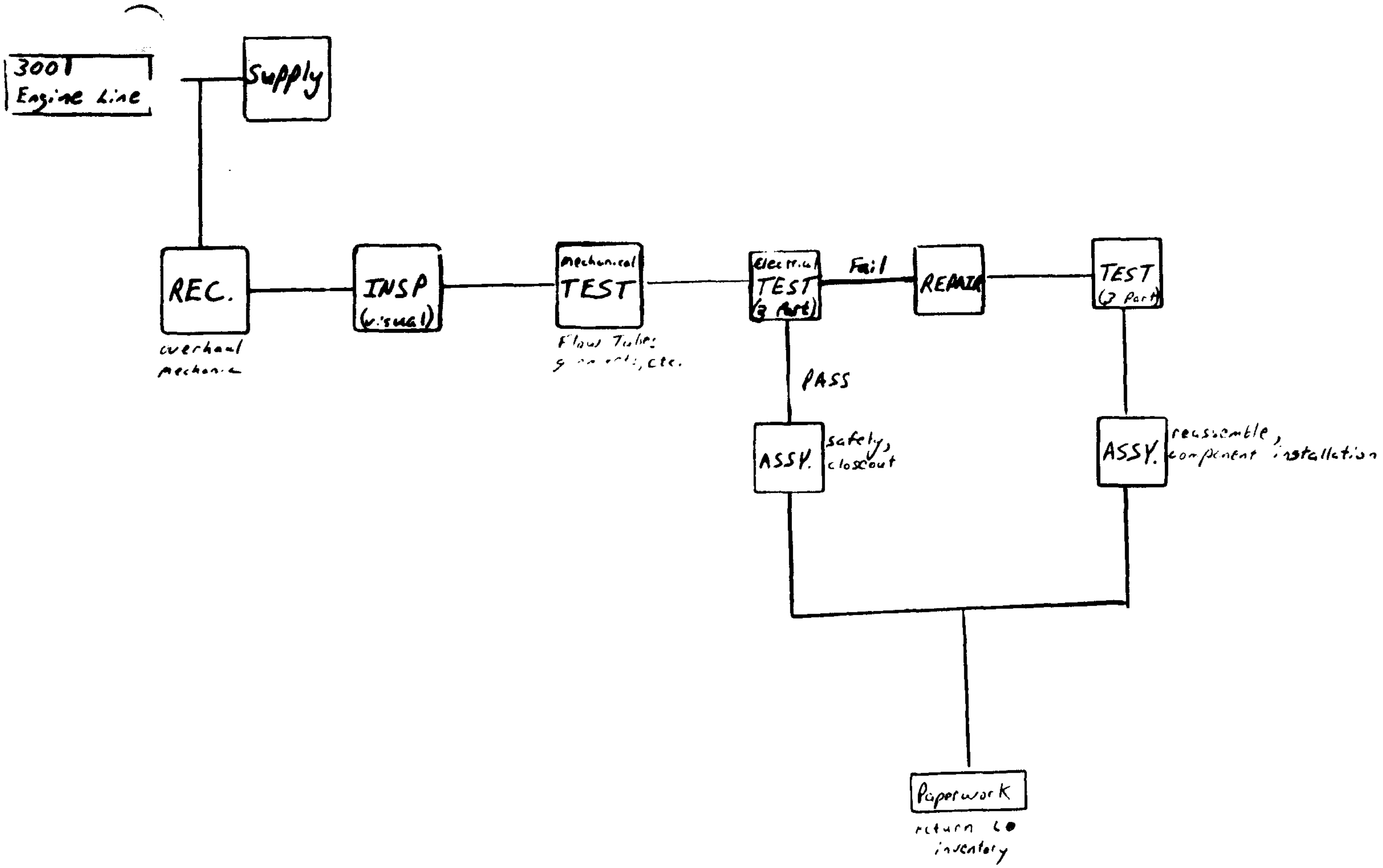
overhaul of



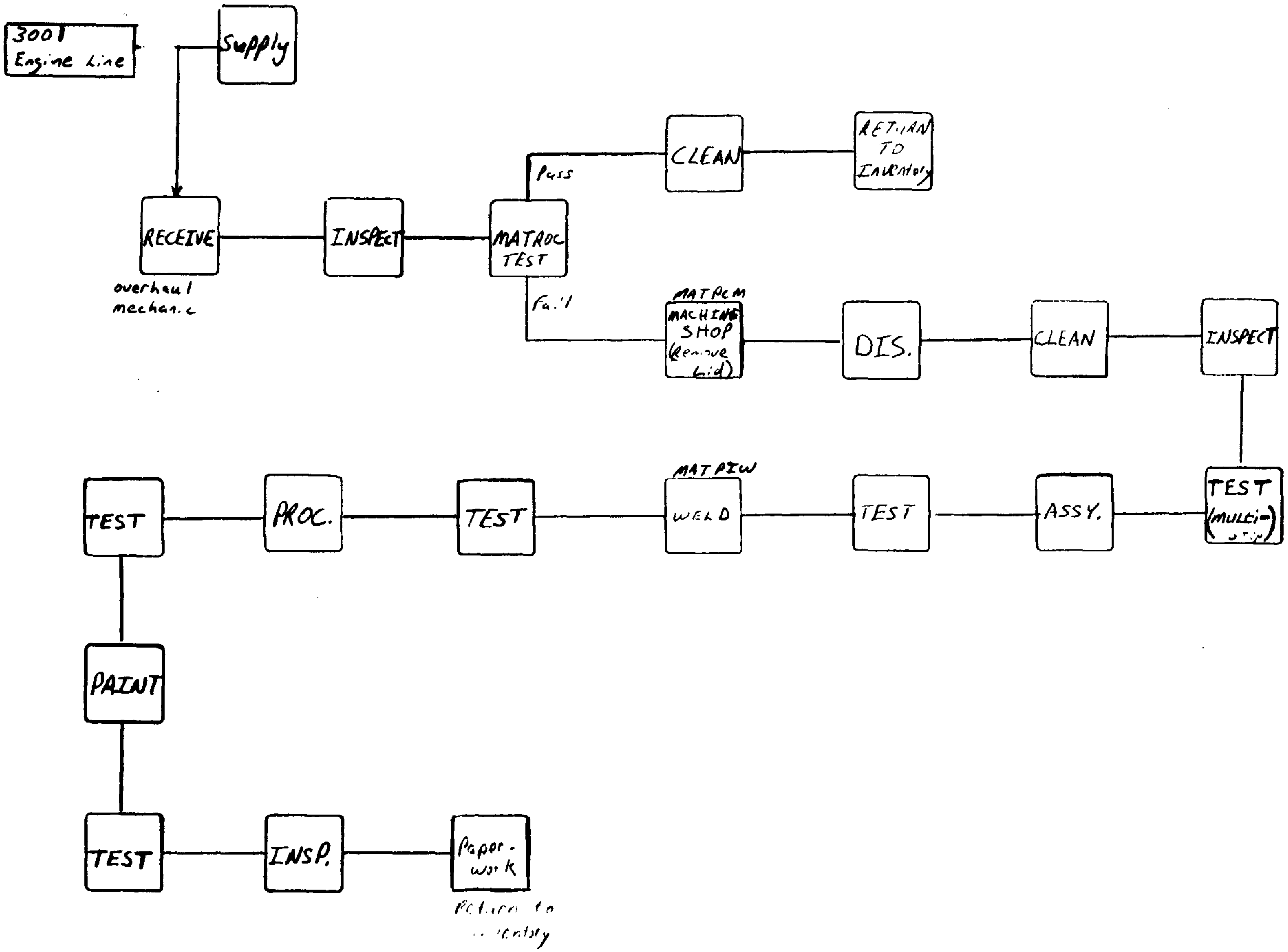
3001
Engine Line
Supply
REC.
overhaul
mechanic
DIS.
CLN.
INSP
TEST
MACH.
ASSY.
TEST
ASSY.
Paperwork
Return to
inventory



300T
Engine Line
Supply
TEST
Fail
DIS.
CLN.
INSP
multi step
ASSY.
TEST
Pass
ASSY.
switch replaced, adjusted
PROC.
INSP
Paper-work
return to inventory
Paper-work
Return to inventory



Fi[illegible] 2 [illegible] overhaul


300
Engine Line
Supply
RECEIVE
overhaul
INSPECT
MATROC
TEST
Pass
Fail
CLEAN
RETURN
TO
INVENTORY
MATPCM
MACHINE
SHOP
(Remove
Lid)
DIS.
CLEAN
INSPECT
TEST
(multi-
MAT PIW
WELD
TEST
ASSY.
TEST
PROC.
TEST
PAINT
TEST
INSP.
Paper-
work

3.0 80/20 WORKLOAD ANALYSIS

An 80/20 analysis was previously performed for MATPCA using information obtained from AFLC "TOP DOLLAR ITEM" lists. These lists assumedly weighted the items on the basis of earned hours reported for each control number worked. In the case of MATPCA, this list proved dated, with several of the PCNs having been reassigned to other RCCs. An updated list was formed by reviewing the recent history of items processed, and replacing those PCNs that were no longer relevant with presently processed items of equal or greater earned hours. The following is the updated list of those part control numbers identified as representing 80% of MATPCA's present workload:

CONTROL NUMBER	WCD NAME
35023A	CAEY10
98093A	CAEC11
34253A	CAAC24
37719A	CAA001
38718A	CAEM02
38645A	CAEM08
30241A	CAEB05
34044A	CAEC04
49711A	CAEC07
*35111A	CAEZ08
34128A	CAEY08
98001A	CAEC07

38694A	CAEM09
50217A	CAEA01
50078A	CAEZ05
38669A	CAEM03
35510A	CAEY12
31151A	CA2222
30056A	CAEZ03
*34252A	CAAC02
*34551A	CAEZ04
*35113A	CAEZ02
38643A	CAEM04
49315A	CAEY09
61234A	CAEC05
*35033A	CAEY11
*97133A	CAEB08
50297A	CAEM22

* These are the PCNs that were placed on this list in order to update it to present conditions observed in MATPCA.

3.1 VALIDATION

Validation of the 80/20 list was performed as described in the preceding section. The updated list is believed to be representative of the MATPCA workload.

4.0 DATA COLLECTION

Of the data profile sheets collected, the following were found to be applicable to the MATPCA RCC:

- Operation Profile
- Manpower Profile
- Equipment Profile

Disassembly/Assembly Profiles and Parallel Process Profiles were not applicable to this RCC due to the nature of the work performed. All information represented on the operation profile sheets was developed primarily from information provided by the interviewed technicians. Manpower availability and equipment profile information was provided by shop supervisors.

4.1 DATA COLLECTION PROCESS

Each control number identified on the 80/20 list had an operation profile developed for it. The applicable shop foreman identified the technician most familiar with the item being studied, and an interview was performed to determine the relevant operations and their associated time requirements.

Please note that while a specific WCD (work control document) is the primary paperwork associated with any particular item's control number, this WCD can not be

regarded as an accurate description of the actual operations required for testing and overhaul of that item. The WCD should instead be considered as only a tracking device for the existing PAC certification program.

WORKLOAD PI FILE

NAME Huggins, Duane ALC Okla City DATE 19 April '89 RCC MATPCA SHEET 1 OF 1

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN 34253A NSN 6130007728567 P/N 17351GHAC	135	CAAC24	4	0	144	177	[illegible]	[illegible]	N/A	20	3.8
PCN 37719A NSN [illegible] 1343 P/N [illegible]	130	CAAE01	4		124	121	155	[illegible]	N/A	30	7.2
PCN 38645A NSN 291500137 [illegible] PL P/N 635E490G01	F4 J79 Eng	CAEM08	4		[illegible]	65	[illegible]	[illegible]	N/A	15	7.9
PCN [illegible] NSN [illegible] 0833457 P/N 3110191G [illegible]	F4 J79 eng	CAEM04	4		47	40	[illegible]	[illegible]	N/A	10	7.5
PCN 35113A NSN 292500156563 3CN P/N 6869188	A7 TF41 eng	CAEZ02	4		[illegible]	48	[illegible]		N/A	8	3.5
PCN 35111A NSN 2925002285485CN P/N 10-382470-3	A7 TF41 Eng	CAEZ01	4		[illegible]	[illegible]	[illegible]	[illegible]	N/A	10	2.5
PCN 34253A NSN 6130007728566 P/N 8TJ51@AA4	135	CAEC0[illegible]	4		40	15	[illegible]		N/A	20	[illegible]
PCN 31151A NSN 1650 00 [illegible] 8003 P/N 632830K	C5D	CAAV0[illegible]	4		90	43	80	70	N/A	40	1.37
PCN 38694A NSN 2925009637864PL P/N	J79 Aft. Jet Valve	CAEM09	4		70	74	82	62	N/A	10	3.8
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											

WORKLOAD PROFILE

NAME Sandra Wishon ALC OC DATE 5/19/89 RCC MATPA SHEET 1 OF 2

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN NSN P/N 35023A	TF 33 3-7-9	CAEY10	4	Ø	84	62	50	65	2	15	12.0
PCN NSN P/N 98093 A	TF 33 P7	CAEC11	4		152	145	124	94	3	30	12.4
PCN NSN P/N 38718 A	J79-15	CAEM02	4		97	97	87	84	4	15	9.2
PCN NSN P/N 30241 A	J57-43	CAEB05	4		223	144	103	50	2	40	6.0
PCN NSN P/N 34044A	TF33-7	CAEC04	4		54	38	47	19	3	10	9.8
PCN NSN P/N 49711A	TF33-3	CAEC07	4		78	79	48	23	2	15	7.2
PCN NSN P/N 34128A	TF33-P111	CAEY08	4		162	140	170	129	NA	45	4.3
PCN NSN P/N 98001A	TF33-3	CAEC07	4		22	26	23	23	2	8	6.7
PCN NSN P/N 38694A	J79-15-17	CAEM09	4		70	81	47	90	NA	10	3.8
PCN NSN P/N 50217A	TF33-5	CAEA01	4		1	5	2	5	2	5	10.0
PCN NSN P/N 49315A	TF30-3-7-9	CAEY09	4		301	209	215	260	NA	50	4.0
PCN NSN P/N 38669A	J79-15-17	CAEM03	4		37	45	35	30	1	10	4.5
PCN NSN P/N 35510 A	TF30-P100	CAEY12	4		21	16	26	2	NA	8	5.2

LSC-2009GB

WORKLOAD)FILE

NAME Sandra Wishon ALC OC DATE 5/19/89 RCC MAT PCA SHEET 2 OF 2

ITEM NUMBER	AIRCRAFT MODEL	WCD	WORKLOAD TYPE	FLOATING STOCK	ACTUAL PRODUCTION BY QUARTER 1	2	3	4	NO. OF ENVELOP UNITS	MAXIMUM W.I.P.	STANDARD HOURS
PCN NSN P/N 30056A	TF41 A1-A2	CAEZ03	4	Ø	27	16	23	19	NA	10	5.2
PCN NSN P/N 50297A	J79-15-17	CAEM22	4		6	0	0	0	NA	6	4.5
PCN NSN P/N 34551A	TF41-A1	CAEZ04	4		23	30	24	15	NA	5	5.2
PCN NSN P/N 97133A	TF33-3	CAEB08	4		39	47	39	12	NA	10	2.9
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											
PCN NSN P/N											

LSC-20096B

EQUIPMENT P')FILE

DUE 27 APR., 1989

NAME Duane Huggins ALC Okla City DATE 15 may 89 RCC MAIPCA SHEET 1 OF 1

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3d	DOWNTIME: PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTDF	MTTR	PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
OC 4286	J79 Temp Am	1	0	0	090	1	00080	365	020	0%	N/A	[illegible]	TMDE Inventory List + Supervisor
OC 4285	J79 Temp AM	1			090	1	00080	365	[illegible]	0%	N/A	[illegible]	TMDE Inventory List + Shop Supervisor
OC 4531	KIT Test Am	1			180	1	00080	730	[illegible]		N/A	OC1076	TMDE Inventory List + Shop Supervisor
OC 3908	Timing Tes 30+	1			NPCR	NA	NA	365	010 In shop	[illegible]	N/A	[illegible]	Shop [illegible]
NA	Rely Bx Tst	1			365	NA	NA	never failed	never failed		N/A	[illegible]	TMDE Inventory List
NA	Auto Ig Tes	1			NPCR	NA	NA	365	in shop		N/A	[illegible]	Shop [illegible]
OC 6585	Solen. Test	1			365	1	00080	never failed	never failed	[illegible]	[illegible]	[illegible]	TMDE Inventory List [illegible]
NA	[illegible] Tst 30	4			180	1	00560	445	[illegible]	0	[illegible]	[illegible]	[illegible]

NCR:

EQUIPMENT PROFILE

DUE 27 APR. 1987

NAME Sandra Wishon ALC OC DATE [illegible] RCC MATPCA SHEET ___ OF ___

EQUIPMENT CODE	EQUIPMENT TYPE/DESCRIPTION	QUANTITY PER SHIFT 1st	2nd	3d	DOWNTIME PREVENTIVE MAINT. FREQ.	SHIFT	DOWN TIME	UNSCHEDULED BREAKDOWN REPAIR TIME MTBF	MTTR	PERCENT USED FOR OTHER RCCs (e.g. TIME NOT AVAILABLE)	ENVELOP UNITS MIN / MAX	ALTERNATE EQUIPMENT CODE	SOURCE
[illegible]	[illegible] TST [illegible] yrs	3			1	1	[illegible]	730	0040	0			[illegible]
OC 3952	IGN TST CON + 20 yr				[illegible]	1	NA	210	0040	0		OC 3953	(
OC 4929	JET IGN TST [illegible] yrs				[illegible]	1	0050	020	0045.0	0		OC 3906	
	IGN TSTR 20 yr	2				1	[illegible]	730	0040	0			
OC C303	ELEC OVEN 20 yrs	1			[illegible]	1	N[illegible]	365	[illegible]	0			
OC 4060	IGN Com TST 20 yrs	1			[illegible]	1	[illegible]	180	[illegible]	0			
OC [illegible]	OVEN 20 yrs	1			[illegible]	1	NA	365	[illegible]	0		OC [illegible]8 OC [illegible]59	
[illegible]	VOLTSTIE [illegible] yrs	2			[illegible]	1	[illegible]	270	[illegible]	0			
[illegible]	PK CAP TST 20 yrs	1			NA	1	[illegible]	180	[illegible]	0			
OC 2429	LEAK DET 20 yrs	1			[illegible]	1	N[illegible]	730		0			

NCR

LSC-2009-1B

Due Tues. APR 25, 1989

MANPOWER PROFILE

NAME Huggins Duane ALC Okla City DATE 19 Apr 89 RCC 2M MT PCA SHEET 1 OF 1

SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE									MANPOWER AVAILABLE (HOURS)									ALTERNATE SKILL CODE/LEVEL
			WORK WEEK			WEEKEND			HOLIDAYS			WORK WEEK			WEEKEND			HOLIDAYS			
			1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	1	2	3	
AY 09	Engine Electrical component Repair/overhaul misc Aircraft Electronic components Repair/overhaul	1	9			7			7			6.0			6.0			6.0			
7		2	7			7			7			5.9			5.9			5.9			
		3	6			6			6			5.9			5.9			5.9			
		4	6			6			6			5.9			5.9			5.9			
AY 10	Engine Electrical componant Repair/overhaul, Misc Aircraft Electronic component Repair/overhaul	1	9			9			9			5.9			5.9			5.9			
		2	7			2			7			5.9			5.9			5.9			
		3	5			5			5			5.9			5.9			5.9			
		4	5			5			5			5.9			5.9			5.9			
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			
		1																			
		2																			
		3																			
		4																			

Note: only one shift at present time

LSC-2009

Due Tues. APR 25, 1989

MANPOWER PROFILE

NAME Sandra Wishon [redacted] ALC Okla City DATE 19 Apr 89 RCC ?? AT PCA SHEET ___ OF ___

SKILL CODE/LEVEL	JOB DESCRIPTION	QUARTER	QUANTITY AVAILABLE WORK WEEK 1	2	3	WEEKEND 1	2	3	HOLIDAYS 1	2	3	MANPOWER AVAILABLE (HOURS) WORK WEEK 1	2	3	WEEKEND 1	2	3	HOLIDAYS 1	2	3	ALTERNATE SKILL CODE/LEVEL
BY 10	overhaul/repair of engine & aircraft electrical & [illegible] accessories. Functional test and troubleshoot, operate special purpose test stand. [illegible]	1	10									6.0			6.0			6.0			
7		2	10									5.9			5.9			5.9			
		3	10									5.9			5.9			5.9			
yrs		4	10									5.9			5.9			5.9			
BY 09	overhaul/repair of engine & aircraft electrical and [illegible] and components.	1	10									6.0			6.0			6.0			
4 yrs		2	10									5.9			5.9			5.9			
		3	10									5.9			5.9			5.9			
		4	10									5.9			5.9			5.9			
BY 07	Train in intermediate position while assisting higher grade in [illegible] and repair engine/aircraft electrical & [illegible] accessories	1	1									6.0			6.0			6.0			
Elect Equip Rpr		2	1									5.9			5.9			5.9			
Target Grade 09		3	1									5.9			5.9			5.9			
1/2		4	1									5.9			5.9			5.9			
B3 07	Perform tasks [illegible] aircraft [illegible] and other equipment	1	1									6.0			6.0			6.0			
		2	1									5.9			5.9			5.9			
		3	1									5.9			5.9			5.9			
		4	1									5.9			5.9			5.9			
BY 07	[illegible] clean blast & final process aircraft engine electrical accessories 25% of line [illegible] WG2854 work	1	1									6.0			6.0			6.0			
		2	1									5.9			5.9			5.9			
DEBLASTER		3	1									5.9			5.9			5.9			
7		4	1									5.9			5.9			5.9			

LSC-20003

ENVE [illegible]P

(For Internal Use, Not a Model Input) (Batch Process Only)

ALC OC RCC MAT PCA EQUIPMENT CODE OC 2760 (OC·2258, 2259 - Alternates)

TOTAL VOLUME OF EQUIPMENT IN CU. FT. 10 [illegible]

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN [illegible] NSN 2925 00941 3728PQ P/N 42127	.1cu.FT	2	1	6	EACH OVEN IS LIMITED TO 6 [illegible] DUE TO FITTINGS
PCN 38649 NSN 2925 00992 1235PL P/N 10-353975-2	.09 cu.FT.	1	1	6	
PCN 98693 NSN 2925 00 456 7687RU P/N 43311	.2cu.FT	3	1	6	
PCN 38718 NSN 2925 01132 58[illegible]PL P/N 10-3[illegible]625-1	.3cu.FT.	4	1	6	
PCN 30041 NSN 2925 00084 8118KU P/N 10-106700-1	.14cu.FT.	2	1	6	
PCN 34041 NSN 2925 00986 2655 KV P/N 42590	.2cu.FT	3	1	6	
PCN 49711 NSN 2925 01 131 6761RU P/N 10-617860-1	.1cu.FT	2	1	6	
PCN 98001 NSN 2925 00773 73[illegible] P/N 11-187860-1	.1cu.FT	2	1	6	
PCN 50317 NSN 2925 01 161 5596RU P/N 44387	.14cu.FT	2	1	6	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

ENVE P

(For Internal Use, Not a Model Input) (BATCH PROCESS ONLY)

ALC OC RCC MATPCA EQUIPMENT CODE OC 0303

TOTAL VOLUME OF EQUIPMENT IN CU. FT. [illegible]

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN 98093 NSN 2529004567637RD P/N 43317	.2 CU. FT	3	1	18	This oven does not have fittings inside
PCN 34C44 NSN 2925009862055RD P/N 42590	.2 CU. FT	3	1	18	
PCN 49711 NSN 2925011318761RD P/N 10-617860-1	.1 CU. FT	2	1	18	
PCN [illegible] NSN [illegible] 00773 7217RD P/N 10-187860-1	.1 CU. FT	2	1	18	
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

ENVELC
(For Internal Use, Not a Model Input)

ALC ______ RCC ______ EQUIPMENT CODE ______

TOTAL VOLUME OF EQUIPMENT IN CU. FT. ______

LIST OF PARTS BY ITEM NUMBER	SIZE/VOLUME CU. FT.	UNIT VALUE	MINIMUM	MAXIMUM	REMARKS/SOURCE
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					note: no batch
PCN NSN P/N					processes ran on any of this equip.
PCN NSN P/N		N/A			listing.
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					
PCN NSN P/N					

LSC-20106A

OPERATION . ROFILE

NAME Parker ALC OC DATE 05/04/89 RCC MAT PCA [redacted]

PCN / NSN / PIN 30056A WCD CAEZ03 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT RA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

* Note - This sheet for in [redacted] dates

LSC-20092C

Hawkins

OPERATION ..OFILE

NAME Parker, Phillip ALC OC DATE 05/04/89 RCC MAT PCA SHEET 1 OF 6

PCN / NSN / PN 30056A WCD CAEZ 03 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.17	–	–	–	–	skill 5-10
020		INFO	1.0	~~TRANSIT~~											Applicable T.O.
				~~SETUP~~											
				~~PROCESS~~				–	–	–	–	–	–	–	skill [illegible]
025		TEST	1.0	~~TRANSIT~~											Note: this op not listed in WCD. Initial function TEST. see Ops 160-2[illegible]
				~~SETUP~~	–	–					–	–	–	–	Equip - DI = dial indicator SA = switch adjust device
				PROCESS	–	–		1	1.0	2.87					skill range 9-1[illegible]
030		DIS	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.18	BEN 4	1	1.0	.18	skill range [illegible]
040		CIN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.25	BEN 4	1	1.0	.18	skill range [illegible]

OPERATION PROFILE

NAME Parker, Philip ALC ... DATE 05/04/87 RCC MAT PCA SHEET 2 OF 6

PCN / NSN / PN 300S6A WCD CAF203 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCA	INSP	1.0	~~TRANSIT~~											Note: This is a visual inspection.
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.17	BEN4	1	1.0	.17	skill range 9-10
060		INSP	1.0	~~TRANSIT~~											Micrometer req.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN4	1	1.0	.17	skill range 9-10
070		INSP	1.0	~~TRANSIT~~											Micrometer req.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN 4	1	1.0	.17	skill range 9-10
080		INSP	1.0	~~TRANSIT~~											Micrometer req.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN4	1	1.0	.17	skill range 9-10
090		INSP	1.0	~~TRANSIT~~											Micrometer req.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN 4	1	1.0	.17	skill range 9-10

LSC-20092C

OPERATION . .OFILE

NAME Parker, Phillip ALC OC DATE 05/04/89 RCC MAT PCA SHEET 3 OF 6

PCN/NSN/PIN 30056A WCD CAEZ03 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCA	INSP	1.0	~~TRANSIT~~											Micrometer req.
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.17	BEN4	1	1.0	.17	skill 9-10
110		INSP	1.0	~~TRANSIT~~											micrometer req
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN 4	1	1.0	.17	skill 9-10
120		PROC	1.0	~~TRANSIT~~											AS Required [illegible]
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.08	BEN4	1	1.0	.17	skill 9-10
130		ASSY	1.0	~~TRANSIT~~											several steps required.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	1.52	BEN4	1	1.0	.17	skill 9-10
140		ASSY	1.0	~~TRANSIT~~											Adjustment required.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.1	BEN 4	1	1.0	.1	skill 9-10

LSC-20092C

OPERATION PROFILE

NAME Ricker, Philip ALC [illegible] DATE 05 [illegible]/89 RCC MAT PCA SHEET 4 OF 6

PCN/NSN/PN 30056A WCD CAEZ03 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCA	ASSY	1.0	~~TRANSIT~~											Adjustment required.
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.18	BEN4	1	1.0	.18	Skill 9-10
155		ASSY	1.0	~~TRANSIT~~											adjustment required.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	BEN4	1	1.0	.17	Skill 9-10
158		ASSY	1.0	~~TRANSIT~~											Requires Torque
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	BEN4	1	1.0	.82	Skill 9-10
160		TEST	1.0	TRANSIT											Test Apparatus: SW, Adjustment Device (SAD)
				SETUP	–	–		1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	1.01	BEN4	1	1.0	1.09	Skill 9-10
170		TEST	1.0	~~TRANSIT~~											Separate test from above.
				~~SETUP~~	–	–		–	–	–	–	–	–	–	
				PROCESS	–	–		1	1.0	.12	BEN4	1	1.0	.12	Skill 9-10

OPERATION . .OFILE

NAME Parker, Phillip ALC OC DATE 05 04 89 RCC MAT PCA SHEET 5 OF 6

PCN / NSN / P/N 30056A WCD CAEZ03 WCD DATE 8820 03

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
220	MAT PCA	TEST	1.0	~~TRANSIT~~											Test Apparatus: Dial Indicator (DT)
				~~SETUP~~	–	–	–	–	–	–	–	–	–	–	
				PROCESS	–	–	BY10	1	1.0	.53	BEN4	1	1.0	.53	Skill 9-10
230		PROC	1.0	~~TRANSIT~~											Special tool required.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.03	BEN4	1	1.0	.03	Skill 9-10
260		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	–	–	–	–	Skill 9-10
270		Insp	1.0	~~TRANSIT~~											Inspect for [illegible] tightness.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	BEN4	1	1.0	.02	Skill 9-10
280		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	[illegible]

LSC-20092C

OPERATION PROFILE

NAME Parker, Phillip ALC CX DATE 05/04/89 RCC MATPCA SHEET 6 OF 6

(PCN) NSN P/N 30056A WCD CAEZD3 WCD DATE 882003

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
290	MAT PCA	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.02	–	–	–	–	Skill 9-10
295		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Skill 9-10
9999	MAT PCA	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	30									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ____________________ DATE 05/04/89

ITEM CODE
PCN ☒ WCD CAEZ303 WCD DATE 88203
NSN. ☐ 30056A
P/N ☐

CHART BEGINS OPN # 010

CHART ENDS OPN # PREPARED BY PJP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	INFO			○ ▷ D □ ▽	
025		○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
030	030	○ ▷ D □ ▽	DIS			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	CIN			○ ▷ D □ ▽	
050	050	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
060	060	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
070	070	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
080	080	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
090	090	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
100	100	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
110	110	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
120	120	○ ▷ D □ ▽	LUB			○ ▷ D □ ▽	
130	130	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
140	140	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
150	150	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
155	155	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
158	158	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
160	160	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
170	170	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
220	220	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
230	230	○ ▷ D □ ▽	ACT			○ ▷ D □ ▽	
260	260	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
270	270	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
280	280	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
290	290	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
295	295	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATPCA SHEET 1 OF 1

PCN 30241A WCD CAEBOS ✓ WCD DATE 89033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	44.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note: This sheet for IN - OUT DATES

OPERATION :OFILE

NAME *Parker* ALC *OC* DATE *05/[illegible]/89* RCC *MAT PCA* SHEET *1* OF *5*

[illegible] Stroud

PCN NSN P/N *30241A* WCD *CAEB05* WCD DATE *89033*

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.08	—	—	—	—	Skill 5-10
015		INFO	1.0	[redacted]											Applicable T.O.
				[redacted]											
				[redacted]											
		TEST	1.0	[redacted]											[illegible] unit routed back [illegible] laboratory,
				SETUP	—	—		1	1.0	.02	—	—	—	—	
				PROCESS	—	—		1	1.0	.07	CC 4929	1	1.0	.09	[illegible] failure rate [illegible]
020		INSP	1.0	[redacted]											visual inspection for [illegible] cracks
				[redacted]											
				PROCESS	—	—		1	1.0	.17	BEN21	1	1.0	.17	Sk[illegible]
030	MAT PCM	MACH	.95	[redacted]											cover removal, normally only machine assigned for this procedure.
				[redacted]											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 2 OF 5

FCN
NSN
P/N 302411A WCD CAE BOS WCD DATE 89099

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	DIS	.95	[redacted]											
				[redacted]											
				PROCESS	–	–	CY 10	1	1.0	.42	BEN21	1	1.0	.42	Skill 9-10
045		TEST	.95	[redacted]											[illegible]
				SETUP	–	–		1	1.0	.33	–	–	–	–	[illegible]
				PROCESS	–			1	1.0	.33	x 3953	1	1.0	.66	Skill 9-10
050	MAT PIW	WELD	.29	[redacted]											[illegible] ba [illegible] cracked, [illegible] be [illegible] (3 [illegible] occurrence)
				[redacted]											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	
310	MAT PCA	ASSY	.95	[redacted]											[illegible] Replace [illegible] necessary.
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.50	BEN 21	1	1.0	.50	Skill 9-10
320		ASSY	.95	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.75	BEN21	1	1.0	.75	Skill 9-10

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PC A SHEET 3 OF 5

PCN/NSN/PN 30241A WCD CAEB05 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
330	MAT PCA	TEST	.95	[redacted]											
				SETUP	-	-	BY10	1	1.0	.02	-	-	-	-	
				PROCESS	-	-	BY10	1	1.0	.17	OC 4929	1	1.0	.19	SKILL 9-10
360	MAT PIW	WELD	.95	[redacted]											... welding ... lid.
				[redacted]											
				PROCESS	1.0	24.0	-	-	-	-	-	-	-	-	
365	MAT PCA	PAINT	1.0	[redacted]											... flow hours.
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.30	-	-	-	-	SKILL ?
370		PROC	.95	[redacted]											... drying.
				[redacted]											
				PROCESS	1.0	2.0	BY10	1	1.0	.05	OC 2758	1	1.0	1.55	SKILL 9-10
380		INFO	.95	[redacted]											
				[redacted]											
				[redacted]											SKILL 9-10

LSC-2002C

OPERATION PROFILE

NAME Packer ALC OC DATE 05/08/89 RCC MATPCA SHEET 4 OF 5

PCN/NSN/PN 30241A WCD CAEBQ5 WCD DATE 890921

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
440	MAT PCA	PROC	.95	[redacted]											Pressurize unit with dry air.
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.07	BEN21	1	1.0	.07	SK...
450		PROC	.95	[redacted]											... for leakage water bath
				[redacted]											
				PROCESS	–	–		1	1.0	.05	BEN17	1	1.0	.05	Skill ...-10
460		TEST	.95	[redacted]											
				SETUP	–	–		1	1.0	.02	–	–	–	–	
				PROCESS	–	–		1	1.0	.07	OC 4929	1	1.0	.09	Skill 9-10
490		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	–	–	–	–	Sk 9-10
500		ASSY	.95	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN21	1	1.0	.25	Skill 9-10

LSC-2(X)92C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 5 OF 5

PCN/NSN/PN 30241A WCD CAEB05 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
510	MAT PCA	PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.03	–	–	–	–	SK. [illegible]
520		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	–	–	–	–	[illegible]
590		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Skill 9-10
9999	MAT RA	Out Date	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	20.0									
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______________________ DATE 05/08/89

ITEM CODE PCN ☒ 30241A NSN ☐ P/N ☐

WCD CAEBOS WCD DATE 89094

CHART BEGINS 010

CHART ENDS 590 PREPARED BY MP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◇D□▽	REC			○◇D□▽	
015	015	○◇D□▽	INFO			○◇D□▽	
017	-	○◇D□▽	TEST			○◇D□▽	
020	020	○◇D□▽	INSP			○◇D□▽	
030	030	○◇D□▽	MACH			○◇D□▽	
040	040	○◇D□▽	DIS			○◇D□▽	
045	-	○◇D□▽	TEST			○◇D□▽	
050	050	○◇D□▽	WELD			○◇D□▽	
310	310	○◇D□▽	ASSY			○◇D□▽	
320	310	○◇D□▽	ASSY			○◇D□▽	
330	-	○◇D□▽	TEST			○◇D□▽	
360	360	○◇D□▽	WELD			○◇D□▽	
365	365	○◇D□▽	Paint			○◇D□▽	
370	—	○◇D□▽	Heat			○◇D□▽	
380	380	○◇D□▽	INFO			○◇D□▽	
440	440	○◇D□▽	Pressurize			○◇D□▽	
450	450	○◇D□▽	Leak test			○◇D□▽	
460	460	○◇D□▽	TEST			○◇D□▽	
490	490	○◇D□▽	Paperwork			○◇D□▽	
500	500	○◇D□▽	Saftey wire			○◇D□▽	
510	510	○◇D□▽	Paper work			○◇D□▽	
520	520	○◇D□▽	Paper work			○◇D□▽	
590	590	○◇D□▽	Paper work			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME J Carter ALC OC DATE 4/28/89 RCC MATPCA SHEET — OF —

PCN / NSN / PN 31151A. WCD CA2222 WCD DATE 88214

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
00	MAT PCA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: THIS SHEET FOR IN-OUT DATES

LSC-200020

OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-28-89 RCC MAT PCA SHEET 1 OF 2

ECN/NSN/P/N 31151 A WCD CA2222 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—	AY09	1	1.0	.10	28 BENCH	1	1.0	.10	SK11 5-10
020	MAT PCA	DIS	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—	—	—	—	—		—	—	—	
				PROCESS	—	—		1	1.00	.75	28 BENCH	1	1.0	.75	
030		CLEAN	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	* NO No. ON CLEANING TANK
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.00	.1	28 BENCH	1	1.0	.1	
040		INSP	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.00	.30	BENCH	1	1.0	.30	
050		REP	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.00	.50	28 BENCH	1	1.0	.50	

OPERATION ..OFILE

NAME J. Carter ALC OC DATE 4/28/89 RCC MAT PCA SHEET 2 OF 2

(RCN) NSN 31151A WCD CA2222 WCD DATE 89094

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
060	MAT PCA	ASS	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	AY 09	1	1.0	.75	28 BENCH				
070		TEST	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	* MEM SK1265
				PROCESS	—	—		1	1.0	.20	28 BENCH				
080		PW	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.1	28 BENCH	—	—	—	
090		PW	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.1	28 BENCH				
100		PW	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	28 BENCH				
9999	MAT PCA	out Date	1.0	Process	1.0	9.6									

LSC-20092C

FLOW PROCESS CHART

SUBJECT GEAR BOX ASS'Y DATE 5-1-89

ITEM CODE WCD [redacted] WCD DATE 88214

PCN ☑ 31151A
NSN ☐
P/N ☐

CHART BEGINS OP 010

CHART ENDS OP 100 PREPARED BY J. CARTER

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	—	●◇D□▽	REC			○◇D□▽	
020	—	●◇D□▽	DISASSEMBLE			○◇D□▽	
030	—	●◇D□▽	CLEAN			○◇D□▽	
040	—	●◇D□▽	INSPECT			○◇D□▽	
050	—	●◇D□▽	REPAIR			○◇D□▽	
060	—	●◇D□▽	ASSEMBLE			○◇D□▽	
070	—	○◇D■▽	TEST			○◇D□▽	
080	—	●◇D□▽	P/W			○◇D□▽	
090	—	●◇D□▽	P/W			○◇D□▽	
100	—	●◇D□▽	P/W			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

NOTE: Added times
Equipment blocks

OPERATION FILE

NAME J. CARTER ALC OC DATE 4-27-82 RCC MAT PCA SHEET 1 OF ___

PCN 34044A
NSN [redacted]
P/N
WCD CAECO4 WCD DATE 82-04-5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN Date	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	2.0									
010	MAT PCA	REC	1.000	TRANSIT			BY.10	—	—	—		—	—	—	
				SETUP				—	—	—		—	—	—	
				PROCESS	—	—		1	—	.10	6 BENCH	1	1.0	.1	BENCH
015		PW	1.000	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	—	.10	6 BENCH	1	1.0	.1	BENCH
020		DIS	1.000	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	—	2.0	6 BENCH	1	1.0	2.0	BENCH
030		CLN	1.000	TRANSIT	—	—		1	—	—	—	—	—	—	
				SETUP	—	—			—	—	—	—	—	—	
				PROCESS	—	—	BY.10	1	—	.1	→	—	—	—	CLEANING TANK - NO NUMBER

LSC-20092C

OPERATIO[illegible] [illegible]FILE

NAME J. CARTER ALC OC DATE 11-27-89 RCC MAT PCA SHEET 2 OF ___

PCN 34649A
NSN [redacted]
P/N ___

WCD CAECO4 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	INSP.	1.000	TRANSIT	—	—	34-10	—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.10	6 [illegible]	1	1.0	.1	
060		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.20	OC 4929	1	1.0	.20	
070		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 4929	1	1.0	.10	
070		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	+	—	
				PROCESS	—	—		1	1.0	.10	OC 4929	1	1.0	.10	
080		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—	34-10	1	1.0	.10	OC 4929	1	1.0	.10	

LSC-2092C

OPERATIO[illegible]FILE

NAME JACK CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 3 OF ____

PCN 34044A
NSN [redacted]
PN ____
WCD CAECO4 ✓
WCD DATE ____

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
090	MAT PCA	TEST	1.00	TRANSIT	—	—	—	—	—	—	—	—	—	—	
				SETUP	—	—	—	—	—	—	—	—	—	—	
				PROCESS	—	—	BY-10	1	1.0	.20	OC 4929	—	—	—	
100		TEST	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—						—	—	—	
				PROCESS	—	—		1	1.0	.10		—	—	—	
110		TEST	1.00	TRANSIT	—	—						—			
				SETUP	—	—						—			
				PROCESS	—	—		1	1.0	.10		—	—	—	
120		TEST	1.00	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—			
				PROCESS	—	—		1,0	1.0	.10	OC 4929	—	—	—	
380		REP		TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—	BY10	1	1.0	.42	6 BENCH	1	1.0	.42	

LSC-20092C

OPERATION FILE

NAME J. CARTER ALC ______ DATE ______ RCC ______ SHEET 4 OF ____

FCN/NSN/PN 34044A WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT	—	—	—	—	—	—	—	—	—	—	COMBINED WITH OP 440 PER ACT FAB. METHOD.
390	MAT PCA	ASS'Y		SETUP	—	—	—	—	—	—	—	—	—	—	
				PROCESS	—	—	BY10	1	1.0	3.0	6 BENCH	1	1.0	3.0	
				TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
460		TEST	1.0	PROCESS	—	—		1	1.0	.15	# OC3953	1	1.0	.15	TEST BENCH
				TRANSIT	—	—			—	—		—	—	—	EPOXY FILL & OVEN BAKE
				SETUP	—	—			—	—		—	—	—	
520		BAKE		PROCESS	1.0	3.0		1	1.0	.1	# OC0363		1.0	.75	
				TRANSIT	—	—									NOTE: CASE IS SOLDER-SEALED AT THIS OPER.
				SETUP	—	—									
525		ASS'Y.		PROCESS				1	1.0	.30	SOLDER 39 BENCH	1	1.0	.3	
				TRANSIT	—	—		1	1—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
530		TEST		PROCESS	—	—	BY16	1	1.0	.10	# OC3952	1	1.0	.10	

OPERATION FILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET 5 OF ___

PCN
NSN
PRI ______ WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT	—	—		—	—	—		—	—	—	
	MAT PCA			SETUP	—	—		—	—	—		—	—	—	
540		TEST	1.00	PROCESS	1.0	.5	BY 10	1	1.0	.10	E OC-3953	1	1.0	.5	
				TRANSIT	1.0	.20			—	—			—	—	PAINT BOOTH RELOCATE
				SETUP	—	—		—	1.0	.2			—	—	FOR LOGISTICS
560		PROC	1.00	PROCESS	1.0	4.0		1	1.0	.3	—		1.0	.75	NO NUMBER PAINT BOOTH
				TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
570		TEST	1.00	PROCESS	—	—		1	1.0	.15	OC 4929	1	1.0	.15	ELEC TEST BENCH
650		PROC		TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	INSTALL
				PROCESS	—	—		1	1.0	.05	6 BENCH	1	1.0	.05	SAFETY WIRE
	MAT			TRANSIT	—	—						—	—	—	
670	PCA	PW	1.00	SETUP	—	—						—	—	—	
				PROCESS	—	—	BY10	1	1.0	.1	6 BENCH	1	1.0	.1	
9999	)	OUT Date	1.0	Process	1.0	28.0									

LSC-2(XX)2C

OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 6 OF 6

PCN
NSN 34044A
PN [redacted]

WCD CAECO4 ✓ WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
580	MAT PCA	PN	1.0	TRANSIT	—	—	BY	—	—	—	—	—	—	—	
				SETUP	—	—	10	—	—	—	—	—	—	—	
				PROCESS	—	—	—	1.0	1.0	.10	BENCH	1	1.0	.10	
9999		out date	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	8.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NAME R
PCN
NSN
PN 30

OPERATION NUMBER
040
045
050
310
320

#3044A

FLOW PROCESS CHART

SUBJECT IGNITION EXCITER DATE 5-2-89

ITEM CODE
PCN ☑
MAN. ☐
P/N ☐

WCD CAEC04 WCD DATE 89045

CHART BEGINS OPER # 010

CHART ENDS OPR # 680 PREPARED BY CARTER

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	REC			○▷D□▽	
015	015	●▷D□▽	VERIFY			○▷D□▽	
020	020	●▷D□▽	DISASSEMBLE			○▷D□▽	
030	030	●▷D□▽	CLEAN			○▷D□▽	
040	040	●▷D□▽	VIS INSP.			○▷D□▽	
050	050	●▷D□▽	TEST			○▷D□▽	
060	060	●▷D□▽				○▷D□▽	
070	070	●▷D□▽				○▷D□▽	
080	080	●▷D□▽				○▷D□▽	
090	090	●▷D□▽				○▷D□▽	
100	100	●▷D□▽				○▷D□▽	
110	110	●▷D□▽				○▷D□▽	
120	120	●▷D□▽	TEST			○▷D□▽	
380	380	●▷D□▽	REPAIR			○▷D□▽	
390	390	○▷D□▽ ●▷D□▽	RE ASSEMBLE & TORQUE			○▷D□▽ ○▷D□▽	
	440	○▷D□▽	COMBINE			○▷D□▽	
460	460	●▷D□▽	TEST			○▷D□▽	
520	520	●▷D□▽	POT & BAKE			○▷D□▽	
525	525	●▷D□▽	SOLDER SEAL			○▷D□▽	
530	530	●▷D□▽	LEAK TEST			○▷D□▽	
540	590	●▷D□▽	TEST			○▷D□▽	
560	560	●▶D□▽	PAINT			○▷D□▽	
570	570	●▷D□▽	FINAL TEST			○▷D□▽	
650	650	●▷D□▽	SAF WIRE			○▷D□▽	
660	660	●▷D□▽	CERT			○▷D□▽	
670	670	●▷D□▽	COMPLY			○▷D□▽	
680	680	●▷D□▽	COMPLY			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE ☐ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

PROBE ASS'Y OPERATION [illegible]FILE

NAME J. CARTER ALC OC DATE 5-5-89 RCC MAT PCA SHEET 1 OF 4 Lilly

PCN NSN P/N 34128A WCD CAE Y08 WCD DATE 88307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	320									
010	MAT PCA	PW	1.0	TRANSIT	—	—	BY 09	—	—	—		—	—	—	BATCH LOTS OF 6 EA.
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	28 BENCH	1	1.0	.10	
015		PW	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	28 BENCH	1	1.0	.10	
017		PROC	1.0	TRANSIT	[illegible]	—	BY 09	1	1.0	.50	—	—	—	—	HEAT TREAT
				SETUP	—	—	—	—	—	—	—	—	—	—	
				PROCESS	1.0	24	—	—	—	—	—	—	—	—	
020	MAT PCA	DISASS	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1.0	1.0	.05	28 BENCH	1	1.0	.05	

OPERATIC... FILE

NAME J. CARTER ALC OC DATE 5/5/89 RCC MATPCA SHEET 2 OF 3

PCN / NSN / P/N 34128A WCD CAEY08 WCD DATE 88 302

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
030	MAT PCA	CLEAN	1.0	TRANSIT	1.0	.50		—	—	—		—	—	—	HEAT TREAT
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	24		—	—	—		—	—	—	
035		CLEAN	1.0	TRANSIT	—	—	BY 07	—	—	—		—	—	—	ADDED SAND BLAST
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	BEN 28	1	1.0	.05	
040		PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	INSPECT STRAIGHTEN
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	BY 09	1	1.0	.10	BEN 28	1	1.0	1.0	
045	MT PIT	INSP	1.0	TRANSIT	1.0	.25		—	—	—		—	—	—	FPI INSP. NOTE: 3 TO 7 WKS
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1	504		—	—	—		—	—	—	
050	MT. PIT	MOVE	1.0	TRANSIT	1	.25		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		—	—	—		—	—	—	

LSC-2(X)92C

OPERATI[illegible] FILE

NAME J Carter ALC OC DATE 5/5/89 RCC MATPCA SHEET 3 OF 4

PCN
NSN 34128A
PN

WCD CAEY08 WCD DATE 88307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
060	MAT PCA	REPAIR	1.0	TRANSIT	—	—	AY09	—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.20	28 BENCH	1	1.0	.20	
070		RE ASS	1.0	TRANSIT	1.0	.2		—	—	—		—	—	—	NOTE: OVEN BAKE AT U-43
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	1.0		1	1.0	.10	28 BENCH	1	1.0	.1	
080		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	28 BENCH	1	1.0	.1	
090		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	28 BENCH	1	1.0	.10	
100		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	NOTE: NO NUMBER ON "JET CAL" TEST STAND
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.50	BEN 31	1	1.0	.5	

OPERATI[illegible]FILE

NAME J. Carter ALC OC DATE 5/5/85 RCC MAT PCA SHEET 4 OF 4

PCN / NSN / PN 34128 A WCD CAEY08 WCD DATE 88307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT PCA	PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1	.05	28 BENCH	1	1.0	.05	SAFETY WIRE
120		PW	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	28 BENCH	1	1.0	.10	
125		PW	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	28 BENCH	1	1.0	.1	
130		PW	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	28 BENCH	1	.10	.10	
145		PW	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	28 BENCH	1	1.0	.10	
9999		OUT [illegible]	1.0	[illegible]	[illegible]	24.0									

FLOW PROCESS CHART

SUBJECT PCN 34128A 'PROBE ASS'Y. DATE 5-5-82

ITEM CODE
PCN ● 34128A
NSN. □
P/N □

WCD CAE Y08 WCD DATE 88307

CHART BEGINS OP 010

CHART ENDS OP 130

PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	REC			○ ▷ D □ ▽	
015	015	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
017		● ▶ D □ ▽	HEAT TREAT			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	DISASSEMBLE			○ ▷ D □ ▽	
030	030	● ▷ D □ ▽	CLEAN			○ ▷ D □ ▽	
035		● ▷ D □ ▽	SANDBLAST			○ ▷ D □ ▽	
040	040	● ▷ D □ ▽	STRAIGHTEN			○ ▷ D □ ▽	
045	045	● ▶ D ■ ▽	FPI			○ ▷ D □ ▽	
050	050	○ ▶ D □ ▽	MOVE			○ ▷ D □ ▽	
060	060	● ▷ D □ ▽	REPAIR			○ ▷ D □ ▽	
070	070	● ▷ D □ ▽	REASSEMBLE			○ ▷ D □ ▽	
080	080	● ▷ D □ ▽	TEST			○ ▷ D □ ▽	
090	090	● ▷ D □ ▽	TEST			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	TEST			○ ▷ D □ ▽	
110	110	○ ▷ D □ ▽ ● ▷ D □ ▽	SAFETY WIRE			○ ▷ D □ ▽ ○ ▷ D □ ▽	
120	120	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
125	125	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
130	130	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATIOI ROFILE

NAME G M Gu-tdry ALC ( ) DATE 5-23-89 RCC MAT PCA SHEET 1 OF 4

~~PCN~~ NSN PN 3H252A WCD CABCD2 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT RA	IN	1,0	TRANSIT											
				SETUP											
				PROCESS	1.0	20.0									
010	MAT PCA	REC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	RY09	1	1.0	.25	BEN 3	1	1.0	.25	SKILL 9-10
050		DIS	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	RY09	1	–	.25	BEN 3	1	1.0	.25	SKILL 9-10
060		CLN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	RY09	1	–	.08	BEN 3	1	1.0	.08	SKILL 9-10
070		INSP	1.0	TRANSIT											
				~~SETUP~~											
				PROCESS	–	–	RY09	1	–	.08	BEN 3	1	1.0	.08	SKILL 9-10

OPERATION PROFILE

NAME GM Ground Eqy ALC OO DATE 5-22-89 RCC MMTPCD SHEET 2 OF 4

PCN
NSN 34252A
PN

WCD CMTCDS WCD DATE 8910

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MMT PCA	Lub	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	AY09	1	–	.02	BEN3	1	1.0	.02	SKILL 9-10
110		ASSY	1.0	TRANSIT											
				~~SETUP~~											
				PROCESS	–	–	AY09	1	–	1.0	BEN3	1	1.0	1.0	SKILL 9-10
115		Test	1.0	TRANSIT											General - Checking, Timing
				~~SETUP~~											
				PROCESS	–	–	AY09	1	–	.20	AC3908	1	1.0	.20	SKILL 9-10
120		OVHL	1.0	TRANSIT											
				~~SETUP~~											
				PROCESS	–	–	AY09	1	–	1.0	BEN3	1	1.0	1.0	SKILL 9-10
121		PROC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	AY09	1	–	.33	BEN3	1	1.0	.33	SKILL 9-10

OPERATION PROFILE

NAME [illegible] ALC N-C DATE 5-22-89 RCC MATPCA SHEET 3 OF 4

PCN
NSN
PN 24052A WCD QRRC02 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
122	MAT PCA	PROC	1.0	TRANSIT											Bake 1.0 Hr. + Cold .25
				SETUP											
				PROCESS	1.0	1.25	BY09	1	–	.03	AC-1076	1	1.0	1.0	Skill 9-10
123	/	Insp	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	BY09	1	–	.25	BEN 3	1	1.0	.25	Skill 9-10
124	/	Test	1.0	TRANSIT											Final-Test
				SETUP											
				PROCESS	–	–	BY09	1	–	.20	BEN 3	1	1.0	.20	Skill 9-10
170	/	PW	1.0	TRANSIT											Complete paperwork.
				SETUP											
				PROCESS	–	–	BY09	1	–	.02	BEN 3	1	1.0	.02	Skill 9-10
171	/	PROC	1.0	TRANSIT											Sand-Blast
				SETUP											
				PROCESS	–	–	BY09	1	–	.25	BEN 3	1	1.0	.25	Skill 9-10

OPERATION PROFILE

NAME Q[illegible] ALC [illegible] DATE 5-22-89 RCC RMTPC12 SHEET 4 OF 4

PCN
NSN
PNI [illegible] WCD [illegible] WCD DATE 89012

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
172	MHT PCH	PAINT	1.0	~~TRANSIT~~											Clean for paint.
				~~SETUP~~											
				PROCESS	1.0	2.0	13307	1	1.0	.30	W59	1	1.0	.3	SKILL 9-1[illegible]
180		PW	1.0	TRANSIT											
				~~SETUP~~											
				PROCESS	–	–	BY09	1	–	.08	–	–	–	–	SKILL 9-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	8.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

APR 20 '89 15:41 MDMSC C-17MSH ASL P04

FLOW PROCESS CHART

SUBJECT ______________________ DATE 5-2?-89

ITEM CODE
PCN ☑
NSN ☐
P/N ☐

WCD CAACO2 WCD DATE 89010

CHART BEGINS 010 - PREPARED BY [illegible]

CHART ENDS 160

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC			○ ▷ D □ ▽	
050	050	○ ▷ D □ ▽	[illegible]			○ ▷ D □ ▽	
060	060	○ ▷ D □ ▽	CLN			○ ▷ D □ ▽	
070	070	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
100	100	○ ▷ D □ ▽	Lub			○ ▷ D □ ▽	
110	110	○ ▷ D □ ▽	[illegible]			○ ▷ D □ ▽	
115	115	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
120	120	○ ▷ D □ ▽	OVHL			○ ▷ D □ ▽	
121	—	○ ▷ D □ ▽	Seal			○ ▷ D □ ▽	
122	—	○ ▷ D □ ▽	[illegible]			○ ▷ D □ ▽	
123	—	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
124	—	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
170	170	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
171	—	○ ▷ D □ ▽	[illegible]			○ ▷ D □ ▽	
172	—	○ ▷ D □ ▽	PAINT			○ ▷ D □ ▽	
180	—	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME GM Gut... ALC C.. DATE 5-17-89 RCC MATPCA SHEET 1 OF 4

PCN / NSN / PN 342 53-A WCD CABC 24 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS hrs.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED hrs.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED hrs.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	320									
010	MAT PCA	[illegible]	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	HY09	1	—	.25	BEN3	1	1.0	.25	SK 11 9-10
020		DIS	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	HY09	1	—	.25	BEN3	1	1.0	.25	SK 11 9-10
030		CLN	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	HY09	1	—	.08	BEN3	1	1.0	.08	SK 11 9-10
040		INSP.	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	HY09	1	-	.08	BEN 3	1	1.0	.08	SK 11 9-10

OPERATION ·OFILE

NAME GM Gwidry ALC OC DATE 5/17/89 RCC MATPCA SHEET 2 OF 4

PCN / NSN / PN 3H253A WCD CAA C211 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCA	Lub	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY09	1	—	.02	BEN3	1	1.0	.02	SK'11 9-10
060	"	ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY09	1	—	1.0	BEN3	1	1.0	1.0	SK'11 9-10
070	"	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY09	1	—	.20	OC3908	1	1.0	.20	SK'11 9-10
080	"	REA	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY09	1	—	1.7	BEN3	1	1.0	1.7	SK'11 9-10
081	"	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY09	1	—	.33	BEN3	1	1.0	.33	SK'11 9-10

OPERATION PROFILE

NAME GM Gurley ALC OC DATE 5-17-89 RCC MATPCA SHEET 3 OF 11

PCN
NSN 5112552
PRI

WCD CAPC 211 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
082	MAT PCA	PROC	1.0	TRANSIT											Bake 1.0 Hrs.
				SETUP											Cold .25
				PROCESS	1.0	1.25	BY09	1	—	.03	OC1076	1	1.0	1.0	Skill 9-10
083		INSP	1.0	TRANSIT											Leak-check
				SETUP											
				PROCESS	—	—	BY09	1	—	.25	BEN3	1	1.0	.25	Skill 9-10
084		TEST	1.0	TRANSIT											Final Test
				SETUP											
				PROCESS	—	—	BY09	1	—	.20	BEN3	1	1.0	.20	Skill 9-10
090		PW	1.0	TRANSIT											Complete paperwork
				SETUP											
				PROCESS	—	—	BY09	1	—	.02	BEN3	1	1.0	.02	Skill 9-10
091		PROC	1.0	TRANSIT											Sand-Blast
				SETUP											
				PROCESS			BY07	1	—	.25	BEN3	1	1.0	.25	Skill 9-10

LSC-2002C

OPERATION PROFILE

NAME GMGuidry ALC OC DATE 5-17-89 RCC MATPCA SHEET 11 OF 11

PCN / NSN / PNI 34253R WCD CRR C211 WCD DATE 89010

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
092	MAT PCA	PRINT	1.0	TRANSIT											CLEAN - B013 PAINT.
				SETUP											
				PROCESS	1.0	2.0	B307	1	1.0	.30	W59	1	1.0	.30	SKILL 9-10
100	MAT PCA	PW	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	RY09	1	–	.08	–	–	–	–	SKILL 9-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______________________ DATE 5/17/89

ITEM CODE
PCN ☒ 34253A
NSN. ☐
P/N ☐

WCD CAHC 24 WCD DATE CAAC 24

CHART BEGINS 010

CHART ENDS 100 PREPARED BY Bill Cushing

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	● ▷ D □ ▽	REC			○ ▷ D □ ▽	
020	020	● ▷ D □ ▽	DIS			○ ▷ D □ ▽	
030	030	● ▷ D □ ▽	CLN			○ ▷ D □ ▽	
040	040	○ ▷ D ■ ▽	INSP			○ ▷ D □ ▽	
050	050	● ▷ D □ ▽	Lub.			○ ▷ D □ ▽	
060	060	● ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
070	070	○ ▷ D ■ ▽	TEST			○ ▷ D □ ▽	
080	080	● ▷ D □ ▽	overhaul			○ ▷ D □ ▽	
081	–	● ▷ D □ ▽	Seal			○ ▷ D □ ▽	
082	–	● ▷ D □ ▽	BAKE			○ ▷ D □ ▽	
083	–	○ ▷ D ■ ▽	INSP			○ ▷ D □ ▽	
084	–	○ ▷ D ■ ▽	TEST			○ ▷ D □ ▽	
090	090	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
091	–	● ▷ D □ ▽	BLEAST			○ ▷ D □ ▽	
092	–	● ▷ D □ ▽	PAINT			○ ▷ D □ ▽	
100	100	● ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION ..OFILE

NAME Parker ALC OC DATE 5/19/85 RCC MAT PCA SHEET __ OF __

(PCN) NSN PN 34551A WCD CAEZ04 ✓ WCD DATE 88161

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	84.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note - This sheet for IN ~~[illegible]~~ DATES

OPERATION ?OFILE

NAME PARKER ALC OC DATE 5/15/89 RCC MATPCA SHEET 1 OF 3

PCN
NSN 34551A WCD CAEZ04 ✓ WCD DATE 88161
PNI

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT RA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.17	–	–	–	–	SKill 9-10
015		INFO	1.0	[redacted]											
				[redacted]											
				[redacted]											
020		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	1	1.0		1	1.0	.5	BEN4	1	1.0	.5	SKill 9-10
030		CLN	1.0	[redacted]											Freon Tank
				[redacted]											
				PROCESS	1	1.0		1	1.0	.5	BEN 32	1	1.0	.5	SKill 9-10
040		INSP	1.0	TRANSIT											Visual - damaged cables or input pins
				SETUP											
				PROCESS	1	1.0		1	1.0	.17	BEN4	1	1.0	.17	SKill 9-10

OPERATION PROFILE

NAME Riker ALC OC DATE 5/15/89 RCC MAT PCA SHEET 2 OF 3

PCN
NSN 34551A WCD CAEZ04 WCD DATE 8895.1
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
065	MAT PCA	TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.33	BEN4	1	1.0	.33	Skill 9-10
090		ASSY	1.0	~~TRANSIT~~											Kit items (replace)
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.25	BEN4	1	1.0	.25	Skill 9-10
110		ASSY	1.0	~~TRANSIT~~											reassy.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.50	BEN4	1	1.0	.50	Skill 9-10
155		TEST	1.0	~~TRANSIT~~											sent to 3108 They do test to with their personnel
				~~SETUP~~											
				PROCESS	1.0	12.0	–	–	–	–	–	–	–	–	
178		TEST	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.33	BEN4	1	1.0	.33	Skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/15/89 RCC MAT PCA SHEET 3 OF 3

PCN NSN PN 34551A WCD CAE 204 ✓ WCD DATE 8861

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
239	MAT PCA	PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.08	–	–	–	–	SKill 5-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 5/15/93

ITEM CODE
PCN ☒ 34551A
NSN. ☐
P/N ☐

WCD CAE Z04 WCD DATE 89055

CHART BEGINS 010

CHART ENDS 239 PREPARED BY MP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC.			○ ▷ D □ ▽	
015	015	○ ▷ D □ ▽	INFO			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	DIS.			○ ▷ D □ ▽	
030	030	○ ▷ D □ ▽	CLN.			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
065	-	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
090	090	○ ▷ D □ ▽	ASSY.			○ ▷ D □ ▽	
110	110	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
155	-	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
178	178	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
239	-	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽ ○ ▷ D □ ▽				○ ▷ D □ ▽ ○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
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		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATIO[illegible]OFILE

NAME J. CARTER ALC OC DATE 5-4-89 RCC MAT PCA SHEET 1 OF 6

NSN P/N 35023A WCD CAEY10 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
010	MAT PCA	REC	1.0	TRANSIT	—	—	AY 10	—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1.0	1.0	.10	7 BENCH	1	1.0	.10	
015	MAT PCA	PW	1.0	TRANSIT				—	—	—		—	—	—	
				SETUP				—	—	—		—	—	—	
				PROCESS				1	1.0	.10	7 BENCH	1	1.0	.10	
020		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	OC 4929	1	1.0	.10	
030		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.10	OC 4929	1	1.0	.10	

OPERATION PROFILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET 2 OF 6

PCN
NSN
P/N ______ WCD ______ ✓ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT											
				SETUP											
				PROCESS											
080	MAT MCH	PROC	1.0	TRANSIT	—	—		—	—	—			—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	24		—	—	—		—	—	—	
085	MAT PCA	DISASS	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.75	? BENCH	1	1.0	.75	
090	MAT PCA	CLEAN	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	+	—	
				PROCESS	—	—		1	1.0	.75	? BENCH	1	1.0	.75	
100		INSPECT	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.05	? BENCH	1	1.0	.05	

OPERATION PROFILE

NAME J. CARTER ALC ______ DATE ______ RCC ______ SHEET 3 OF 6

PCN
NSN
P/N ______ WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
110	MAT PIW	WLD	1.0	TRANSIT			AY 10								
				SETUP											
				PROCESS	1.0	24									
130	MAT PCA	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.05	OC 3953	1	1.0	.05	
140		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.05	OC 6523	1	1.0	.05	
150		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1	1.0	.05	OC 6523	1	1.0	.05	
160		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS				1.0	1.0	.05	OC 3953	1	1.0	.05	

OPERATIO[illegible]OFILE

NAME ______ ALC ______ DATE ______ RCC ______ SHEET 4 OF 6

PCN
NSN
P/N ______ WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MAT PCA	TEST	1.0	TRANSIT	—	—	AY-10	—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	? BENCH	1	1.0	.05	
180		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	? BENCH	1	1.0	.05	
190		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	COMBINE OP 190, 200 & 210
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.01	OC 3952	1	1.0	.01	
220		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	OC 3952	1	1.0	.05	
230		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 3906	1	1.0	.10	

OPERATION PROFILE

NAME J. CARTER ALC ______ DATE ______ RCC ______ SHEET 5 OF 6

PCN
NSN
P/N ______ WCD ______ ✓ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
240	MAT PCA	TEST	01	TRANSIT	—	—		—	—	—		—	—	—	COMBINED OP 240, 250, 260, & 270
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 3906	1	1.0	.10	
280		TEST	01	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	OC 6523	1	1.0	.05	
290		TEST	01	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.05	OC 3953	1	1.0	.05	
300		REPAIR	01	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.50	? BENCH	1	1.0	.50	
310		REASS	01	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	? BENCH	1	1.0	.10	

OPERATION PROFILE

NAME J. CARTER ALC ______ DATE ______ RCC ______ SHEET 6 OF 6

PCN
NSN
P/N ______ WCD ______ WCD DATE ______

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
320	MAT PCA	TEST	1.0	TRANSIT	—	—	AY 10	—	—	—		—	—	—	COMBINE OP 220 & 230
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	? BENCH	1	1.0	.10	
340	MT PIW	WELD	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	24		—	—	—		—	—	—	
350	MT PIW	WELD	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	24.0		—	—	—		—	—	—	
360		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	COMBINE OP 360 & 380
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	? BENCH	1	1.0	.10	
390		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 4929	1	1.0	.10	
9999		OUT	1.0	Process	1.0	48.0									

LSC-20092C

FLOW PROCESS CHART

SUBJECT 35023A DATE 5-4-89

ITEM CODE
PCN ☐
NSN. ☐
P/N ☐

WCD CAEY10 WCD DATE 89094

CHART BEGINS OP 010

CHART ENDS OP 390 PREPARED BY J. CARTER

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●◗D□▽	REC	320	320	●◗D□▽	TEST
015	015	●◗D□▽	VERIFY		330	●◗D□▽	
020	020	●◗D□▽	TEST	340	340	●◗D□▽	
030	030	●◗D□▽	TEST		350	●◗D□▽	
	040	●◗D□▽		360	360	●◗D□▽	TEST
	050	●◗D□▽			380	●◗D□▽	
	060	●◗D□▽	TEST	390	390	●◗D□▽	TEST
070	070	●◗D□▽	DIS ASS		400	●◗D□▽	
080	080	●◗D□▽	MACHINE		410	●◗D□▽	
090	090	●◗D□▽	CLEAN	420	420	●◗D□▽	PW
100	100	●◗D□▽	INSP	460	460	●◗D□▽	PW
110	110	●◗D□▽	WELD	470	470	●◗D□▽	PW
130	130	●◗D□▽	TEST	475	475	●◗D□▽	PW
140	140	●◗D□▽	TEST			○◗D□▽	
150	150	●◗D□▽ ●◗D□▽	TEST			○◗D□▽ ○◗D□▽	
160	160	●◗D□▽	TEST			○◗D□▽	
180	180	○◗D□▽	TEST			○◗D□▽	
190	190	●◗D□▽	TEST			○◗D□▽	
	200	●◗D□▽	TEST			○◗D□▽	
	210	●◗D□▽	TEST			○◗D□▽	
220	220	●◗D□▽	TEST			○◗D□▽	
230	230	●◗D□▽	TEST			○◗D□▽	
240	240	●◗D□▽	TEST			○◗D□▽	
	250	●◗D□▽	TEST			○◗D□▽	
	260	●◗D□▽	TEST			○◗D□▽	
	270	●◗D□▽	TEST			○◗D□▽	
280	280	●◗D□▽	TEST			○◗D□▽	
290	290	●◗D□▽	TEST			○◗D□▽	
300	300	●◗D□▽	REPAIR			○◗D□▽	
310	310	●◗D□▽	REASSEMB			○◗D□▽	
320	320	●◗D□▽	TEST			○◗D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◗ TRANSPORTATION D DELAY * COMBINE

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/2[illegible] RCC MATPCA SHEET __ OF __

PCN / NSN / PN 35033A WCD CAEY11 WCD DATE 58307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	19.2									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note: This sheet for IN - OUT DATES

OPERATION PROFILE

NAME Parker ALC OC DATE 5/22/89 RCC MAT PCA SHEET 1 OF 2

PCN / NSN / PNI 35033A WCD CAEY11 ✓ WCD DATE 58307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.02	–		–	–	Skill 5-10
015		INFO	1.0	[redacted]											
				[redacted]											
				P[redacted]											Skill 5-10
020		DIS	1.0	[redacted]											Remove cover.
				[redacted]											
				PROCESS	–	–		1	1.0	.50	BEN19	1	1.0	.50	Skill 5-10
030		CLN	1.0	[redacted]											Topical
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN19	1	1.0	.50	Skill 5-10
040		INSP	1.0	[redacted]											for cracked channel boards, etc. (visual)
				[redacted]											
				PROCESS	–	–		1	1.0	.08	BEN19	1	1.0	.08	Skill 5-10

OPERATION ?OFILE

NAME Parker ALC OC DATE 05/23/89 RCC MAT PCA SHEET 2 OF 2

PCN NSN 35033 A PN

WCD CAEY ✓ WCD DATE 88303

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCA	TEST	1.0	[redacted]											multimeter req
				[redacted]											(20% fail)
				PROCESS	–	–	BY10	1	1.0	.05	Ben 19	1	1.0	.05	SA:11 5-10
070		REP	.20	[redacted]											replace terminal board, includes soldering
				[redacted]											
				PROCESS	–	–		1	1.0	1.0	BEN 19	1	1.0	1.0	15% replacement) SA:11 5-10
075		TEST	1.0	TRANSIT											functional test
				SETUP											
				PROCESS	–	–		1	1.0	.10	BEN 19	1	1.0	.10	SA:11 5-10
080		ASSY	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.07	BEN 19				SA:4 5-10
115		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.05	–	–	–	–	SA:11 9-10
9999		OUT	1.0			0									

LSC.2000?C?

FLOW PROCESS CHART

SUBJECT ______ DATE 5/22/89

ITEM CODE
PCN ☐
NSN. ☐
P/N ☐

WCD CAEY11 WCD DATE 89093

CHART BEGINS 010

CHART ENDS 115 PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC			○▷D□▽	
015	015	○▷D□▽	INFO			○▷D□▽	
020	020	○▷D□▽	DIS			○▷D□▽	
030	030	○▷D□▽	CLN.			○▷D□▽	
040	040	○▷D□▽	INSP			○▷D□▽	
050	050	○▷D□▽	TEST			○▷D□▽	
070	070	○▷D□▽	REPAIR			○▷D□▽	
080	080	○▷D□▽	ASSY			○▷D□▽	
115	—	○▷D□▽	PW			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽ ○▷D□▽				○▷D□▽ ○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME GmGurdury ALC GC DATE 5-22-89 RCC MATPCA SHEET 1 OF 6

PCN/NSN/PN 3611IP-CA WCD CAEZ08 WCD DATE 88227

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
010	MAT PCA	REC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	1.0	.17	BEN1	1	1.0	.17	SKILL-9
015	"	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	"	.25	BEN1	1	1.0	.25	
020	"	DIS	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	"	.33	BEN1	1	1.0	.33	SKILL-9
030	"	CLN	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	"	.33	BEN1	1	1.0	.33	SKILL-9

OPERATION FILE

NAME G M Gwinn ALC OC DATE 5-22-89 NCC MATPCP SHEET 2 OF 6

NSN / PN 35111A WCD CHEZCE WCD DATE 88224

OPERATION NUMBER	NCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MATPCP	INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	RY10	1	-	.25	BEN 1	1	1.0	.25	SKILL 9-10
050		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	RY10	1	-	.08	BEN 1	1	1.0	.08	SKILL 9-10
060		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	RY10	1	-	.08	BEN 1	1	1.0	.08	SKILL 9-10
070		REP	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	RY10	1	-	.25	BEN 1	1	1.0	.25	SKILL 9-10
130		Lub	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	RY10	1	-	.08	BEN 1	1	1.0	.25	SKILL 9-10

OPERATION PROFILE

NAME GNGI [illegible] ALC QC DATE 5-22-89 RCC MATPCP SHEET 3 OF 6

ECN / NSN / PN 35111B WCD CAEZ.CD WCD DATE 88227

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT PCB	ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-	AY10	1	-	.50	BEN1	1	1.0	.50	SKILL 9-10
150		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-	AY10	1	-	.08	BEN 1	1	1.0	.08	SKILL 9-10
160		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-	AY10	1	-	.08	BEN 1	1	1.0	.08	SKILL 9-10
170		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-	AY10	1	-	.08	BEN1	1	1.0	.08	SKILL 9-10
180		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	-	-	AY10	1	-	.08	BEN1	1	1.0	.08	SKILL 9-10

OPERATION PROFILE

NAME GM Guthry ALC CC DATE 5-22-89 RCC MAT PCA SHEET 4 OF 6

PCN
NSN 35111A
PRI

WCD CA4Z08 WCD DATE 88227

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
190	MAT PCA	ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	AY10	1	—	.25	BEN1	1	1.0	.25	SKILL 9-10
200		ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY10	1	—	.17	BEN1	1	1.0	.17	SKILL 9-10
210		[illegible]	1.0	TRANSIT											This operation should be at op #180.
				SETUP											
				PROCESS	—	—	AY10	1	—	.08	BEN1	1	1.0	.08	SKILL 9-10
220		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY10	1	—	.25	BEN1	1	1.0	.25	SKILL 9-10
240		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	AY10	1	—	.08	BEN1	1	1.0	.08	SKILL 9-10

OPERATION PROFILE

NAME [illegible] ALC [illegible] DATE [illegible] RCC [illegible] SHEET 5 OF 6

PCN
NSN
PRI [illegible] WCD [illegible] WCD DATE [illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS Hrs.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED Hrs.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED Hrs.	DATA SOURCE COMMENTS
310	IMAT PCA	TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	A1/10	1	–	.03	BEN 1	1	1.0	.03	SKILL 9-10
320	~	REP	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	A1/10	1	–	.02	BEN 1	1	1.0	.02	SKILL 9-10
330	~	Test	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	A1/10	1	–	.08	BEN 1	1	1.0	.08	SKILL 9-10
340	~	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	A1/10	1	–	.10	BEN 1	1	1.0	.10	SKILL 9-10
350	~	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	A1/10	1	–	.17	BEN 1	1	1.0	.17	SKILL 9-10

LSC-2000[illegible]

OPERATION PROFILE

NAME BM Bus... ALC OC DATE 5-22-89 RCC MATPCA SHEET 6 OF 6

PCN / NSN / PN 2EIIIA... WCD CHEZ08 WCD DATE 88227

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
360	MAT PCA	ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	1BY10	1	—	.25	BEN 1	1	1.0	.25	SKILL-9-10
370		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	1BY10	1	—	.02	BEN 1	1	1.0	.02	SKILL 9-10
380		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	1BY10	1	—	.08	BEN 1	1	1.0	.08	SKILL 9-10
390		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	1BY10	1	-	.02	BEN 1	1	1.0	.02	SKILL 9-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	33.6									

FLOW PROCESS CHART

SUBJECT ______________________________ DATE [illegible]

ITEM CODE
PCN ☐ 351119
NSN ☐
P/N ☐

WCD CAE 707 WCD DATE 88227

CHART BEGINS 010 -

CHART ENDS 390

PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	Plac.			○▷D□▽	
015	015	○▷D□▽	Place			○▷D□▽	
020	020	○▷D□▽	[illegible]			○▷D□▽	
030	030	○▷D□▽	[illegible]			○▷D□▽	
040	040	○▷D□▽	[illegible]			○▷D□▽	
050	050	○▷D□▽	[illegible]			○▷D□▽	
060	060	○▷D□▽	[illegible]			○▷D□▽	
[illegible]	070	○▷D□▽	[illegible]			○▷D□▽	
130	130	○▷D□▽	[illegible]			○▷D□▽	
140	140	○▷D□▽	Assy			○▷D□▽	
150	150	○▷D□▽	Place.			○▷D□▽	
160	160	○▷D□▽	Place.			○▷D□▽	
170	170	○▷D□▽	Place			○▷D□▽	
180	180	○▷D□▽	Place.			○▷D□▽	
190	190	○▷D□▽	Assy			○▷D□▽	
200	200	○▷D□▽	Assy			○▷D□▽	
210	210	○▷D□▽	Place.			○▷D□▽	
220	220	○▷D□▽	Place.			○▷D□▽	
240	240	○▷D□▽	Test			○▷D□▽	
[illegible]	240	○▷D□▽	Test			○▷D□▽	
320	320	○▷D□▽	Re-work?			○▷D□▽	
330	330	○▷D□▽	Test			○▷D□▽	
340	340	○▷D□▽	Place			○▷D□▽	
350	350	○▷D□▽	Place			○▷D□▽	
360	360	○▷D□▽	Wire			○▷D□▽	
370	370	○▷D□▽	Place.			○▷D□▽	
380	380	○▷D□▽	P/W			○▷D□▽	
339	390	○▷D□▽	P/W			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME CMCurtDuy ALC OC DATE 5-22-89 RCC MATPCA SHEET 1 OF 4

PCN/NSN/PN 35113A WCD CAEZ02 WCD DATE 88202

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
010	MAT PCA	REC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	1.0	.25	BEN 1	1	1.0	.25	Skill-9-10
015		PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1		.50	BEN 1	1	1.0	.50	Skill-9-10
020		[illegible]	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1		.50	BEN 1	1	1.0	.50	Skill-9-10
030		CLN	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1		.08	BEN 1	1	1.0	.08	Skill-9-10

OPERATION PROFILE

NAME [illegible] ALC OC DATE 5-22-89 RCC MATPCA SHEET 2 OF 4

PCN/NSN/PNI 35113A... WCD CAEZ02 WCD DATE 88202

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MAT			TRANSIT											
040	PCA	INSP	1.0	SETUP											
				PROCESS	-	-	AY10	1	-	.17	BEN 1	1	1.0	.17	SKILL-9
				TRANSIT											Mechanic, do not have any time for [illegible],
050		REPL	1.0	SETUP											
				PROCESS	-	-	AY10	1	-	.50	BEN 1	1	1.0	.50	only for Repl. [illegible]
				TRANSIT											Potting -
051		PROC	1.0	SETUP											Chassis
				PROCESS	-	-	AY10	1	-	.50	BEN 1	1	1.0	.50	SKILL-9
				TRANSIT											
060		ASSY	1.0	SETUP											
				PROCESS	-	-	AY10	1	-	.17	BEN 1	1	1.0	.17	SKILL-9
				TRANSIT											Connectors
070		ASSY	1.0	SETUP											
				PROCESS	-	-	AY10	1	-	.02	BEN 1	1	1.0	.02	SKILL-9

OPERATION PROFILE

NAME OmGuidiry ALC RC DATE 5-22-84 RCC MATPCB SHEET 3 OF 4

PCID NSN PN 35113A WCD CAEEZ02 WCD DATE 88202

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCB	ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	–	.02	BEN 1	1	1.0	.02	SKILL-9
110		ASSY	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	–	.02	BEN 1	1	1.0	.02	SKILL-9
120		Test	1.0	TRANSIT											Cold Start-Test Machine, OR NC, OC Neumann, Sorensen-Power Supply
				SETUP											
				PROCESS	–	–	AY10	1	–	.03	BEN 1	1	1.0	.03	SKILL-9
130		Set	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	-	.03	BEN 1	1	1.0	.03	SKILL-9
140		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	AY10	1	–	.03	BEN 1	1	1.0	.03	SKILL-9

OPERATION ?ROFILE

NAME Gm Crwdey ALC OC DATE 5-22-89 RCC MATPCA SHEET 4 OF 4

PCN / NSN / PNI 35113 B WCD CAEZ02 WCD DATE 88202

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MAT			TRANSIT											CLEAN FOR PAINT,
141	PCA	PAINT	1.0	SETUP											
				PROCESS	1.0	2.0	B307	1	1.0	.30	WS9	1	1.0	.30	Skill-9
				TRANSIT											
150		PROC	1.0	SETUP											
				PROCESS	-	-	BY10	1	-	.08	BEN 1	1	1.0	.08	Skill-9
				TRANSIT											
160		PROC	1.0	SETUP											
				PROCESS	-	-	BY10	1	-	.02	BEN 1	1	1.0	.02	Skill-9
				TRANSIT											Completed paperwork
170		PW	1.0	SETUP											
				PROCESS	-	-	BY10	1	-	.08	BEN 1	1	1.0	.08	Skill-9
				TRANSIT											
175		REP	1.0	SETUP											
				PROCESS	-	-	BY10	1	-	3.50	BEN 1	1	1.0	3.5	Skill-9
9999	(	OUT	1.0	PROCESS	1.0	19.2									

FLOW PROCESS CHART

SUBJECT ______ DATE 88202

ITEM CODE
PCN ■ 351131
NSN. □
P/N □

WCD CAEZ02 WCD DATE 89135

CHART BEGINS 010 —

CHART ENDS 175 PREPARED BY G McC[illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	REC			○▷D□▽	
015	015	●▷D□▽	PROC			○▷D□▽	
020	020	●▷D□▽	[illegible]			○▷D□▽	
030	030	●▷D□▽	CLN			○▷D□▽	
040	040	○▷D■▽	INSP			○▷D□▽	
050	050	●▷D□▽	REPL			○▷D□▽	
051	—	●▷D□▽	POT			○▷D□▽	
060	060	●▷D□▽	ASSY			○▷D□▽	
070	070	●▷D□▽	CONN'T			○▷D□▽	
100	100	●▷D□▽	CONNT			○▷D□▽	
110	110	●▷D□▽	CONNT			○▷D□▽	
120	120	○▷D■▽	TEST			○▷D□▽	
130	130	●▷D□▽	SET			○▷D□▽	
140	140	●▷D□▽	SET			○▷D□▽	
141	—	●▷D□▽	PRINT			○▷D□▽	
150	150	●▷D□▽	PROC			○▷D□▽	
160	160	●▷D□▽	PROC			○▷D□▽	
170	170	●▷D□▽	PW			○▷D□▽	
175	175	●▷D□▽	REP			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/9/89 RCC MAT PCA SHEET - OF -

PCN/NSN/P/N 35510 A WCD CAEY 12 WCD DATE 88037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: THIS SHEET FOR IN-OUT DATES

LSC-20092C

OPERATIO[illegible] [illegible]ROFILE

NAME Parker ALC OC DATE [illegible]5/9/89 RCC MAT PCA SHEET 1 OF 8

PCN NSN P/N 35510 A[illegible] WCD CAEY12 WCD DATE 88037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	-	-	BY10	1	[illegible]	.08	-			-	SK[illegible] 7-10
[illegible]15		INF[illegible]	1.0	[redacted]											
				[redacted]											
				[redacted]											SK[illegible] 5-10 8-10
017		TEST	1.0	TRANSIT	-	-		1	1.0	.25	-		-	-	[illegible] kept
				SETUP				1	1.0	.50	-				[illegible] of delay
				PROCESS	-	-		1	1.0	.17	OC 1944	1	1.0	.67	[illegible] of 10 [illegible] units
018		TEST	1.0	[redacted]											
				SETUP	—	—		1	1.0	.08	-		—	—	
				PROCESS	—	—		1	1.0	.17	3906	1	1.0	.25	SKill 5-0
019		TEST	1.0	[redacted]											spark gap tester
				SETUP	—	—		1	1.0	.08	-	-	-	-	
				PROCESS	—	—		1	1.0	.17	4060	1	1.0	.25	SK[illegible] 7-10

LSC-20092C

OPERATIO. .ROFILE

NAME PARKER ALC C DATE 05/9/C RCC MAT PCA SHEET 2 OF 8

(PCN) NSN P/N 35510 A WCD CAEY12 ✓ WCD DATE 8803 7

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
020	MAT PCM	MACH	.50	[redacted]											one machine [illegible] for [illegible] work,
				[redacted]											
				PROCESS	1.0	24.0	–								Sk.l [illegible]
030	MAT PCA	DIS	.50	[redacted]											
				[redacted]											
				PROCESS	–	–	CY10	1	1.0	.67	BEN4	1	1.0	.67	Skill [illegible]
040	MAT PIW	WELD	.08	[redacted]											per unit,
				[redacted]											
				PROCESS	1.0	24.0				–	–		–	–	[illegible] take this [illegible]
050	MAT PCA	CLN	.50	[redacted]											
				[redacted]											
				PROCESS			W110	1	1.0	.33	BEN 4	1	1.0	.33	[illegible]
060		INSP	.50	[redacted]											visual insp.
				[redacted]											
				PROCESS	–	–		1	1.0	.17	BEN 4	1	1.0	.17	Skill [illegible]

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/19/8 RCC MAT PCA SHEET - OF 8

PCN NSN PIN 35510 A WCD CAEY12 WCD DATE 58037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
070	MAT PCA	TEST	.50	[redacted]											[illegible] tester [illegible] analysis
				SETUP	-		BY10	1	1.0	.17	-	-	-	-	
				PROCESS	—	-		1	1.0	.50	BEN15	1	1.0	.67	SKill 9-10
080		TEST	.50	[redacted]											
				SETUP	-	-		1	1.0	.05	-	-	-	-	
				PROCESS	-	-		1	1.0	.02	OC 4060	1	1.0	.07	SK[illegible] 9-10
090		[illegible]	.50	[redacted]											
				SETUP	-			1	1.0	.02	-	-	-	-	
				PROCESS	-			1	1.0	.03	OC 3906	1	1.0	.05	SKill 9-10
100		TEST	.50	[redacted]											
				SETUP	-			1		.03					
				PROCESS				1		.02	OC 3906	1	1.0	.05	SKill 9-10
110		TEST	.50	[redacted]											
				SETUP	-	-		1		.05	—	—	—	—	
				PROCESS	-	-		1	1.0	.02	OC 4060	1	1.0	.07	SKill 9-10

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE [illegible] RCC [illegible] SHEET 1 OF 8

PCN NSN PN 35510 A WCD CAEY12 WCD DATE 8 3

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
120	MAT PCA	TEST	.50	[redacted]											
				PROCESS	–	–	BY10	1	1.0	.02	BEN4	1	1.0	.02	SKILL 9-10
130		TEST	.50	[redacted]											
				PROCESS	–	–		1	1.0	.02	BEN4	1	1.0	.02	SKILL 9-10
140		TEST	.50	[redacted]											
				PROCESS				1	1.0	.02	BEN4	1	1.0	.02	SKILL 9-10
150		TEST	.50	[redacted]											
				PROCESS	–	–		1	1.0	.02	BEN4	1	1.0	.02	SKILL 9-10
160		TEST	.5	[redacted]											
				PROCESS	–	–		1	1.0	.02	BEN4	1	1.0	.02	SKILL 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 05/0 /89 RCC MAT PCA SHEET 5 OF 8

PCN/NSN/P/N 35570A WCD CAEY12 WCD DATE 88033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MAT PCA	TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–		BY10	1	1.0	.02	BEN4	1	1.0	.02	Skill 9-10
180		TEST	.50	[redacted]											
				SETUP	–	–		1	1.0	.03	–	–	–		
				PROCESS	–	–		1	1.0	.07	4060	1	1.0	.10	Skill 9-10
190		TEST	.50	[redacted]											
				SETUP	–	–		1	1.0	.03	–	–			(2nd pt test)
				PROCESS	–	–		1	1.0	.07	4060	1	1.0	.10	Skill 9-10
200		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.03	BEN4	1	1.0	.03	Skill 9-10
210		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.03	BEN4	1	1.0	.03	Skill 9-10

OPERATION OFILE

NAME Parker ALC OC DATE 05/09/89 RCC MAT PCA SHEET 5 OF 8

PCN/NSN/P/N 35510 A WCD CAEY12 WCD DATE 88037

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
220	MAT PCA	TEST	.50	[redacted]											SK.11 9-10
				SETUP	–	–	BY10	1	1.0	.02	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC 4060	1	1.0	.05	
230		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.03	BEN4		1.0	.03	SK.11 9-10
240		TEST	.50	[redacted]											
				SETUP	–	–		1	1.0	.02	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC 3906	1	1.0	.05	SK.11 9-10
245		PROC	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.33	BEN 4	1	1.0	.33	SK.11 9-10
250		ASSY	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.67	BEN 4	1	1.0	.67	SK.11 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 05/09/89 RCC MAT PCA SHEET 7 OF 8

PCN/NSN 35510A WCD CAEY12 WCD DATE 89037

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
255	MAT PCA	TEST	.50	[redacted]											
				SETUP	-		CY10	1	1.0	.03	-	-	-	-	
				PROCESS	-	-	"	1	1.0	.05	OC 3906	1	1.0	.08	SKill 9-10
260	MAT PTW	WELD	.50	[redacted]											
				[redacted]											
				PROCESS	1.0	24.0	-				-				SKill 9-10
290	MAT PCA	TEST	.50	[redacted]											(280,290 included)
				[redacted]											SKill 9-10
				PROCESS	-	-	BY10	1	1.0	.12	BEN4			.12	[illegible]
300		INSP	.50	[redacted]											
				[redacted]											
				PROCESS	-	-		1	1.0	.03	BEN17	1	1.0	.03	SKill 9-10
310		TEST	.50	TRANSIT											
				SETUP	-	-		1	1.0	.03	-	-	-	-	
				PROCESS	-	-		1	1.0	.05	OC 4060	1	1.0	.08	SKill 9-10

LSC-2(X)92C

OPERATION ?OFILE

NAME Packer ALC OC DATE 05/9/89 RCC MATPCA SHEET 8 OF 8

PCN / NSN / P/N 35510 A WCD CAEY12 WCD DATE 88032

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
320	MAT PCA	TEST	50	TRANSIT											
				SETUP	–	–	BY10	1	1.0	.03	–	–	–	–	
				PROCESS	–	–		1	1.0	.05	cx 3906	1	1.0	.08	SKill 9-10
330		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	–	–	–	–	SKill 9-10
350		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Sk 9-10
360		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	SKill 9-10
3[illegible]		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Sk 9-10
9999		OUT	1.0	Process	1.0	28.8									

LSC-20092C

FLOW PROCESS CHART

SUBJECT ______ DATE 05/09/89

ITEM CODE FCN ☒ 35510A NSN. ☐ P/N ☐ WCD CAE412 WCD DATE 88037

CHART BEGINS 010

CHART ENDS 365 PREPARED BY ______

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC.	290	290	○▷D□▽	TEST
015	015	○▷D□▽	INFO	300	300	○▷D□▽	INSP
017	-	○▷D□▽	TEST	310	310	○▷D□▽	TEST
018	-	○▷D□▽	TEST	320	320	○▷D□▽	TEST
019	-	○▷D□▽	TEST	330	330	○▷D□▽	PW
020	020	○▷D□▽	MACH	350	350	○▷D□▽	PW
030	030	○▷D□▽	DIS	360	360	○▷D□▽	PW
040	040	○▷D□▽	WELD	365	365	○▷D□▽	PW
050	050	○▷D□▽	CLN			○▷D□▽	
060	060	○▷D□▽	INSP			○▷D□▽	
070	070	○▷D□▽	TEST			○▷D□▽	
080	080	○▷D□▽	TEST			○▷D□▽	
090	090	○▷D□▽	TEST			○▷D□▽	
100	100	○▷D□▽	TEST			○▷D□▽	
110	110	○▷D□▽	TEST			○▷D□▽	
120	120	○▷D□▽	TEST			○▷D□▽	
130	130	○▷D□▽	TEST			○▷D□▽	
140	140	○▷D□▽	TEST			○▷D□▽	
150	150	○▷D□▽	TEST			○▷D□▽	
160	160	○▷D□▽	TEST			○▷D□▽	
170	170	○▷D□▽	TEST			○▷D□▽	
180	180	○▷D□▽	TEST			○▷D□▽	
190	190	○▷D□▽	TEST			○▷D□▽	
200	200	○▷D□▽	TEST			○▷D□▽	
210	210	○▷D□▽	TEST			○▷D□▽	
220	220	○▷D□▽	TEST			○▷D□▽	
230	230	○▷D□▽	TEST			○▷D□▽	
240	240	○▷D□▽	TEST			○▷D□▽	
245	245	○▷D□▽	PROC			○▷D□▽	
250	250	○▷D□▽	ASSY			○▷D□▽	
255	—	○▷D□▽	TEST			○▷D□▽	
260	260	○▷D□▽	WELD			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

5.3 ALC

~~24~~ 12/1.1K

OPERATION PROFILE

NAME W. CARTER ALC OK CA DATE 5-4-89 RCC MAT PCA SHEET 1 OF 3

PCN / NSN / PN 37719 A WCD CAA001 WCD DATE 86291

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	32.0									
010	MAT PCA	REC	1.0	~~TRANSIT~~	—	—		—	—	—		—	—	—	
				~~SETUP~~	—	—		—	—	—		—	—	—	
				PROCESS	—	—	AY10	1.0	1.0	.1	—	—	—	—	
020		DIS	1.0	~~TRANSIT~~	—	—		—	—	—		—	—	—	
				~~SETUP~~	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1.0	1.0	.5	BEN 7	1	1.0	.5	
030		CLEAN	1.0	~~TRANSIT~~				—	—	—					
				~~SETUP~~				—	—	—					
				PROCESS	—	—		1.0	1.0	.5	BEN 7	1	1.0	.50	
040		INSP	1.0	~~TRANSIT~~				—	—	—					180 DAY CAL.
				~~SETUP~~				—	—	—					10% TO MCL SHOP
				PROCESS	—	—		1.0	1.0	2.0	BEN 7	1	1.0	2.0	(COMUTATOR)

OPERATION ..OFILE

NAME Carter ALC OC DATE 5/4/89 RCC MAT PCA SHEET 2 OF 3

NSN/PN 37719A WCD CAA001 WCD DATE 86291

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCA	REP	1.0	TRANSIT	—	—		—	—	—		—	—	-	
				SETUP	—	—		—	—	—		—	—	-	
				PROCESS	—	—	AY10	1	1.0	.75	BEN 7	1	1.0	.75	
060		ASSY	1.0	TRANSIT											ARBOR PRESS
				SETUP											
				PROCESS				1	1.0	1.3	BEN 7	1	1.0	1.3	
070		TEST	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	3.0		1	1.0	.75	BEN 7	1	1.0	.75	(4) TEST STANDS MULTI GAGE
080		PH	1.0	TRANSIT	—	—									
				SETUP	—	—									
				PROCESS	—	—		1	1.0	.75	BEN 7	1	1.0	.75	
090		PH	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1.0	.10	BEN 7	1	1.0	.20	

OPERATION PROFILE

NAME Carter ALC OC DATE 5/4/87 RCC MAT RCA SHEET 3 OF 3

PCN / NSN / P/N 37719A WCD CAR001 WCD DATE 86291

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
160	MAT RCA	PH	1.0	~~TRANSIT~~	—	—									
				~~SETUP~~	—	—									
				PROCESS	—	—	AY10	1	1.0	.10	—	—	—	—	
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	20.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 5/4/89

ITEM CODE
PCN ☒ 37719A
NSN ☐
P/N ☐

WCD CAAU Ø1 WCD DATE 86291

CHART BEGINS 010

CHART ENDS 100 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	DIS			○ ▷ D □ ▽	
030	030	○ ▷ D □ ▽	CLN.			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
050	050	○ ▷ D □ ▽	REP.			○ ▷ D □ ▽	
060	060	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
070	070	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
080	080	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
090	090	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
100	100	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽ ○ ▷ D □ ▽				○ ▷ D □ ▽ ○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET - OF -

PCN / NSN / PNI 38643A WCD CAEM04 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
									TIME REQUIRED				TIME REQUIRED		
					%	HRS.	SKILL CODE/ LEVEL	QTY.	%	HRS.	EQUIPMENT CODE	QTY.	%	HRS.	
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note : This sheet for IN - OUT DATES

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 1 OF 5

wallace wyle

PCN
NSN 38643A
P/N

WCD CAEM04 WCD DATE 88389

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT KA	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	AY 10	1	1.0	.02	–	–	–	–	Skill 9-10
020		INFO	1.0	[redacted]											
				[redacted]											
				[redacted]											Skill 9-10
030		INSP	1.0	[redacted]											Visual
				[redacted]											
				PROCESS	–	–				.03	BEN 19	1	1.0	.03	Skill 9-10
035		INSP	1.0	[redacted]											Flow time ... done in bld. 3108 by MATPCA tech
				SETUP	–	–		1	1.0	.17					
				PROCESS	–	–		1	1.0	.12	OC 1135	1	1.0	.29	Skill 9-10
040		TEST	1.0	[redacted]											... time of 20 min for machine ... at
				SETUP				1	1.0	.07	–	–	–	–	
				PROCESS	1.0	.33		1	1.0	1.0	OC 4285	1	1.0	1.40	Skill 9-10

OPERATION . OFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATPCA SHEET 2 OF 5

PCN/NSN/PNI 38643A WCD CAEM04 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
045	MAT PCA	TEST	1.0	T[redacted]											H.7 test 45 min warm up
				SETUP	—	—	—	1	1.0	.03	—	—	—	—	note: combined test, several steps
				PROCESS	1.0	.75	AY10	1	1.0	1.0	OC 4285	1	1.0	1.78	skill 5-10
120		INFO	1.0	[redacted]											80% pass all tests, routed to inventory
				[redacted]											
				[redacted]											
130		DIS	.20	[redacted]											includes removal of potting compound.
				[redacted]											
				PROCESS	–	–		1	1.0	.75	BEN29	1	1.0	.75	
140		CLN	.20	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.33	BEN29	1	1.0	.33	
150		INSP	.20	[redacted]											Visual
				[redacted]											
				PROCESS	–	–		1	1.0	.17	BEN29	1	1.0	.17	

OPERATION ?OFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT ACA SHEET 3 OF 5

PCN / NSN / P/N 38643A WCD CAEM09 WCD DATE 58239

(Note: All failures mostly at ambient temperatures)

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
151	MAT ACA	REP	.15	[redacted]											75% of all failures involve M3 module & require its removal and replacement
				[redacted]											
				PROCESS	—	-	AY10	1	1.0	.50	BEN19	1	1.0	.50	
152		REP	.04	[redacted]											Both the M4 and M2 modules fail 10% of the time and require removal & replacement
				[redacted]											
				PROCESS	—	—		1	1.0	1.0	BEN19	1	1.0	1.0	Skill 5-10
153		REP	.01	[redacted]											The M5 module fails approx. 5% of the time and requires replacement.
				[redacted]											
				PROCESS	—	—		1	1.0	2.0	BEN19	1	1.0	2.0	Skill 5-10
160		INSP	.20	[redacted]											inspect potentiometer
				[redacted]											
				PROCESS	—	—		1	1.0	.08	BEN19	1	1.0	.08	Skill 5-10
170		ASSY	.20	[redacted]											
				[redacted]											
				PROCESS	—	-		1	1.0	.75	BEN19	1	1.0	.75	Skill 5-10

LSC-20092C

OPERATION :OFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 4 OF 5

PCN/NSN P/N 38643A WCD CAEM04 ✓ WCD DATE 88289

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
185	MAT PCA	ASSY	.20	[redacted]											several steps, including drying time.
				[redacted]											
				PROCESS	1.0	1.0	AY 10	1	1.0	.67	OC # 4285	1	1.0	1.67	SK. 11 9-10
270		TEST	.20	[redacted]											several steps involved, "Hot" test.
				SETUP	–	–		1	1.0	.03	–	–	–	–	
				PROCESS	–	–		1	1.0	1.0	OC # 4285	1	1.0	1.03	SK. 11 9-10
340		TEST	.20	[redacted]											Shock test
				[redacted]											
				PROCESS	–	–		1	1.0	.17	BEN 19	1	1.0	.17	SK. 11 9-10
350		TEST	1.0	[redacted]											mechanical pressure test
				[redacted]											
				PROCESS	–	–		1	1.0	.17	BEN 19	1	1.0	.17	SK. 11 9-10
360		TEST	1.0	[redacted]											vibration test
				[redacted]											
				PROCESS	–	–		1	1.0	.50	BEN 19	1	1.0	.50	SK. 11 9-10

OPERATION . .OFILE

NAME Parker ALC OC DATE 5/16/85 RCC MATPCA SHEET 5 OF 5

PCN / NSN / P/N 38643A WCD CAEM04 WCD DATE 88299

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
399	MAT PCA	PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	.22	–	–	–	–	Skill 910
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 5/16/89

WCD CAEM04 WCD DATE 89094

ITEM CODE
PCN ☒ 38143A
NSN. ☐
P/N ☐

CHART BEGINS 010 –

CHART ENDS 399 PREPARED BY HP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	INFO			○ ▷ D □ ▽	
030	030	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
035	035	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
120	120	○ ▷ D □ ▽	INFO			○ ▷ D □ ▽	
130	130	○ ▷ D □ ▽	OIS			○ ▷ D □ ▽	
140	140	○ ▷ D □ ▽	CLN			○ ▷ D □ ▽	
150	150	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
151	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
152	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
153	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
160	160	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
170	170	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
185	–	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
270	270	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
340	340	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
350	350	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
360	360	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
399	–	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

FLOW PROCESS CHART

SUBJECT ____________________ DATE 5/16/89

ITEM CODE
PCN ☒
NSN. ☐
P/N ☐

WCD CAEA01 WCD DATE 86128

CHART BEGINS 010

CHART ENDS 547 PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○ ▷ D □ ▽	REC			○ ▷ D □ ▽	
015	015	○ ▷ D □ ▽	INFO			○ ▷ D □ ▽	
017	–	○ ▷ D □ ▽	Sandblast			○ ▷ D □ ▽	
018	–	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
020	020	○ ▷ D □ ▽	REP.			○ ▷ D □ ▽	
021	–	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
022	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
023	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
024	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
025	–	○ ▷ D □ ▽	REP			○ ▷ D □ ▽	
040	040	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
085	–	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
360	360	○ ▷ D □ ▽	ASSY			○ ▷ D □ ▽	
405	–	○ ▷ D □ ▽	INSP			○ ▷ D □ ▽	
435	–	○ ▷ D □ ▽	PROC			○ ▷ D □ ▽	
460	460	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
470	470	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
490	490	○ ▷ D □ ▽	TEST			○ ▷ D □ ▽	
499	499	○ ▷ D □ ▽	PAINT			○ ▷ D □ ▽	
547	547	○ ▷ D □ ▽	PW			○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	
		○ ▷ D □ ▽				○ ▷ D □ ▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCA SHEET 1 OF 4

PCN / NSN / PN 50292A WCD CAEM22 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.02	BEN4	1	1.0		skill 9-10
020		INFO	1.0	[redacted]											
				[redacted]											
				[redacted]											skill 9-10
030		INSP	1.0	TRANSIT											visual insp. for
				SETUP											d.., scratches
				PROCESS	–	–		1	1.0	.03	BEN4	1	1.0	.03	depth, insul.., ... skill 9-10
r-5		TEST	1.0	[redacted]											(5% Fail)
				SETUP	–	–		1	1.0	.07	–	–	–	–	
				PROCESS	–	–		1	1.0	.07	OC 3906	1	1.0	.14	skill 9-10
040	MAT PCM	MACH	.05	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	

x.5

OPERATION PROFILE

NAME Parker ALC 2C DATE 5/19, 89 RCC MAT PCA SHEET — OF —

PCN
NSN
PN 50297A

WCD CAE M22 ✓ WCD DATE 88 239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT											
00	MAT PCA	IN	1.0	SETUP											
				PROCESS	1.0	19.2									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note: This sheet for IN-OUT Dates

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OPERATION ROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MAT PCA SHEET 1 OF 4

PCN NSN 38645A P/N WCD CAEMO8 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	28.0									
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	.02	–	–	–	–	Skill 5-10
020		INFO	1.0	[redacted]											Applicable TO
				[redacted]											
				[redacted]											
030		INSP	1.0	[redacted]											
				S[redacted]P											
				PROCESS	–	–		1	1.0	.03	BEN 20	1	1.0	.03	Skill 5-10
040		TEST	1.0	[redacted]											Flow tube test performed in 3108
				SETUP	–	–		1	1.0	.17	–	–	–	–	by MATPCA technician
				PROCESS	–	–		1	1.0	.12	OC 1135	1	1.0	.29	(Note: appr 5% fail. see pg 217) Skill 5-10

LSC-20092C

OPERATION .ROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MAT PCA SHEET 2 OF 4

PCN
NSN
P/N 3B645A WCD CAEM08 ✓ WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
050	MAT PCA	TEST	1.0	~~TRANSIT~~											megger used several steps.
				~~SETUP~~											
				PROCESS	–	–	AY 10	1	1.0	1.0	BEN 20	1	1.0	1.0	skill 5-10
059		TEST	1.0	~~TRANSIT~~											Ambient test, warm-up time for machine required. several steps
				SETUP	–	–		1	1.0	.07	–	–	–	–	
				PROCESS	1.0	1.0		1	1.0	1.0	oc # 4286	1	1.0	2.07	skill 5-10
205		TEST	1.0	~~TRANSIT~~											adjustment of temperature required, i.e. flow i.e.
				SETUP	–	–		1	1.0	.03	–	–	–	–	(cold Test)
				PROCESS	1.0	1.0		1	1.0	1.0	oc # 4286	1	1.0	2.03	- must fail at this temp - skill 5-10
215		TEST	1.0	~~TRANSIT~~											(Hot test)
				SETUP	–	–		1	1.0	.03	–	–	–	–	
				PROCESS	1.0	1.0		1	1.0	1.0	oc # 4286	1	1.0	2.03	skill 5-10
216		INFO	1.0	~~TRANSIT~~											Note - 60% pass all tests) and are routed to inventory.
				~~SETUP~~											
				~~PROCESS~~											

Note: A module failure at any point in the testing

LSC-2(X)92C

OPERATION PROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MATPCA SHEET 3 OF 4

PCN/NSN/PN 38645 A WCD CAEM08 ✓ WCD DATE 89 094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
217	MAT PCA	REP	.02	~~TRANSIT~~											5% of all failed items require repair or replacement of fueling tubes, grommets, connectors, etc. Found upon visual inspection.
				~~SETUP~~											
				PROCESS	—	—	AY 10	1	1.0	1.0	BEN 20	1	1.0	2.0	
218		TEST	.38	~~TRANSIT~~											-All other failures than above involve modules (95%). — This is a troubleshooting test, use oh-meter, oscilloscope, voltmeter, etc.
				~~SETUP~~											
				PROCESS	—	—		1	1.0	1.0	BEN 20	1	1.0	1.0	
221		REP	.10	~~TRANSIT~~											Replacement of module A1 (25% failure)
				~~SETUP~~											
				PROCESS	—	—		1	1.0	2.0	BEN 20	1	1.0	2.0	Time includes testing
222		REP	.08	~~TRANSIT~~											Replacement of Module A2 (20% failure)
				~~SETUP~~											
				PROCESS	—	—		1	1.0	2.5	BEN 20	1	1.0	2.5	Time includes testing
223		REP	.11	~~TRANSIT~~											Replacement of module A3 (30% failure rate)
				~~SETUP~~											
				PROCESS	—	—		1	1.0	9.0	BEN 20	1	1.0	9.0	Note: this is a select F.T port. (see note)

OPERATION . ROFILE

NAME Parker ALC OC DATE 5/10/89 RCC MAT PCA SHEET 4 OF 4

PCN 38645A WCD CAEMOF ✓ WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
224	MAT PCA	REP	.08	[redacted]											Replacement of #4 module, includes test time. (20% Failure) SK. 11 5-10
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	3.0	BEN 20	1	1.0	3.0	
225		REP	.02	[redacted]											Replacement of module #5, including test time (5% failure) Skill 5-10
				[redacted]											
				PROCESS	–	–		1	1.0	3.0	BEN 20	1	1.0	3.0	
310		ASSY	.40	[redacted]											Final assy., including RTV and oven time, plus 1.0 hr cooling time SK. 11 5-10
				[redacted]											
				PROCESS	1.0	2.17		1	1.0	1.25	OC 4286	1	1.0	1.17	
320		TEST	.40	[redacted]											Final Testing, same as ops 059, 205, 215 combined. SK. 11 5-10
				SETUP				1	1.0	.13	–	–	–	–	
				PROCESS	1.0	3.0		1	1.0	3.0	OC 4286	1	1.0	6.13	
330		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.17	–	–	–	–	
4999		OUT	1.0	Process		16.0									

LSC-20092C

FLOW PROCESS CHART

SUBJECT ______ DATE 5/10/89

ITEM CODE PCN NSN P/N 38645A   WCD CAEM08   WCD DATE 89 094

CHART BEGINS 010

CHART ENDS ______   PREPARED BY MP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◁D□▽	REC			○◁D□▽	
020	020	○◁D□▽	INFO			○◁D□▽	
030	030	○◁D□▽	INSP			○◁D□▽	
040	040	○◁D□▽	TEST			○◁D□▽	
050	050	○◁D□▽	TEST			○◁D□▽	
055	–	○◁D□▽	TEST			○◁D□▽	
205	–	○◁D□▽	TEST			○◁D□▽	
215	–	○◁D□▽	TEST			○◁D□▽	
216	–	○◁D□▽	INFO			○◁D□▽	
217	–	○◁D□▽	REP			○◁D□▽	
218	–	○◁D□▽	TEST			○◁D□▽	
221	–	○◁D□▽	REP			○◁D□▽	
222	–	○◁D□▽	REP			○◁D□▽	
223	–	○◁D□▽	REP			○◁D□▽	
224	–	○◁D□▽	REP			○◁D□▽	
225		○◁D□▽	REP			○◁D□▽	
310	310	○◁D□▽	ASSY			○◁D□▽	
320	320	○◁D□▽	TEST			○◁D□▽	
330	330	○◁D□▽	PW			○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	
		○◁D□▽				○◁D□▽	

○ OPERATION   ▽ STORAGE   □ INSPECTION
◁ TRANSPORTATION   D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/5/89 RCC MAT PCA SH[redacted]

PCN/NSN 38669A WCD CAEM03 WCD DATE 88239

PN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

* Note: This sheet for in-out dates

LSC-20092C

OPERATION PROFILE

NAME Parker, Phillip ALC OC DATE 5/[illegible]/89 RCC MAT PCA SHEET 1 OF 2

PCN / NSN / P/N 38669A WCD CAEM03 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.03			–	–	SK [illegible] 9-10
020		INFO	1.0	~~TRANSIT~~											Reference to applicable T.O.
				~~SETUP~~											
				~~PROCESS~~											
025		INFO	1.0	~~TRANSIT~~											MAOI 65-4
				~~SETUP~~											
				~~PROCESS~~											
027		CLN	1.0	TRANSIT											Added per [illegible]
				SETUP											
				PROCESS	–	–		1	1.0	.17	BEN2	1	1.0	.17	
030		INSP	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.03	BEN2	1	1.0	.03	

LSC-20092C

OPERATION . . IOFILE

NAME Parker, Phillip ALC OC DATE 5/5/c RCC MAT PCA SHEET 3 OF 7

PCN NSN P/N 38664A WCD CAEM03 WCD DATE 88289

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
035	MAT PCA	TEST	1.0	~~TRANSIT~~											Continuously observed test, 3 parts.
				SETUP	-	-	BY10	1	1.0	.10	-	-	-	-	
				PROCESS	-	-	BY10	1	1.0	.08	OC4929	1	1.0	.07	SKILL 9-10
040	MAT PEM	MACH	1.0	~~TRANSIT~~											Sent to machine shop. Normally only one machine designated.
				[redacted]											
				PROCESS	1.0	24.0	-	-	-	-	-	-	-	-	SKILL
045	MAT PCA	DIS	1.0	~~TRANSIT~~											replace parts as needed
				~~SETUP~~											
				PROCESS	-	-	BY10	1	1.0	.15	BEN2	1	1.0	.15	SKILL 9-10
050	MAT PCA	CLN	1.0	~~TRANSIT~~											cleaning tank CT 1301
				~~SETUP~~											
				PROCESS	-	-		1	1.0	.07	BEN32	1	1.0	.07	
055		INSP	1.0	~~TRANSIT~~											micrometer req.
				~~SETUP~~											
				PROCESS	-	-		1	1.0	.12	BEN2	1	1.0	.12	SKILL

LSC-20092C

OPERATION . :OFILE

NAME Parker, Phillip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 3 OF 7

PCN/NSN/P/N 38669A WCD CAEM03 WCD DATE 68239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
060	MAT PCA	TEST	1.0	~~TRANSIT~~											test stand: Tube [illegible] (TT 100)
				SETUP	–	–	BY10	1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	.02	BEN15	1	1.0	.02	SK 11 7-10
065		TEST	1.0	~~TRANSIT~~											
				SETUP	–	–		1	1.0	.17	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC3952	1	1.0	.03	SK 11 7-10
070		TEST	1.0	~~TRANSIT~~											Volt [illegible]
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.08	BEN2	1	1.0	.08	SK 11 7-10
075		TEST	1.0	~~TRANSIT~~											
				SETUP	–	–		1	1.0	.42	–	–	–	–	
				PROCESS	–	–		1	1.0	.05	OC3952	1	1.0	.05	SK 11 7-10
080		TEST	1.0	~~TRANSIT~~											[illegible] analyzer [illegible]
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.08	OC4060	1	1.0	.08	SK 11 9-10

OPERATION IOFILE

NAME Parker, Phillip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 4 OF 7

NSN P/N 38669A WCD CAE M03 ✓ WCD DATE 88899

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
085	MAT PCA	TEST	1.0	~~TRANSIT~~											capacitor analyzer and MEGGAR (500 V) req.
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.17	0C4060	1	1.0	.08	Skill 9-10
090		ASSY	1.0	~~TRANSIT~~											As required, removed and replaced.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.25	BEN2	1	1.0	.25	
095		ASSY	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.33	BEN2	1	1.0	.33	
100		INFO	1.0	~~TRANSIT~~											
				~~SETUP~~											
				~~PROCESS~~											
105		TEST	1.0	~~TRANSIT~~											[illegible]
				SETUP	–	–		1	1.0	.1	–	–	–	–	
				PROCESS	–	–		1	1.0	.08	0C4929	1	1.0	.07	Sk 9-10

LSC-20092C

OPERATION :OFILE

NAME Parker, Philip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 5 OF 7

PCN NSN P/N 38669A WCD CAE MO3 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT PIW	WEID	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	
115	MAT PCA	TEST	1.0	~~TRANSIT~~											[illegible] press. N_2.
				~~SETUP~~											
				PROCESS	—	—	BY 10	1	1.0	.10	BEN	1	1.0	.10	[illegible]
120		PROC	1.0	~~TRANSIT~~											Placed in oven.
				SETUP	—	—		1	1.0	.05	—	—	—	—	
				PROCESS	1.0	4.75		1	1.0	.10	OC 2758	1	1.0	4.75	[illegible]
123		TEST	1.0	~~TRANSIT~~											water bath used. [illegible] bath [illegible] test temp. must be raised.
				~~SETUP~~											
				PROCESS	—	—		1	.50	.35	WB 140	1	.50	.35	[illegible]
125		PAINT	1.0	[redacted]											P[illegible] [illegible] ully loaded [illegible] this shop.
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.3	W59	1	1.0	.30	two hour drying time. [illegible]

LSC-20092C

OPERATION . IOFILE

NAME PARKER, Phillip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 6 OF 7

NSN/PN 38669A WCD CAEM03 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
130	MAT PCA	TEST	1.0	~~TRANSIT~~											[illegible] 4S opn. 085
				SETUP	–	–	BY10	1	1.0	.10	–	–	–	–	
				PROCESS	–	–		1	1.0	.08	OC4929	1	1.0	.07	Skill 9-10
145		INSP	1.0	~~TRANSIT~~											Insp for correct ID on [illegible]
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.08	BEN2	1	1.0	.08	Skill 9-10
150		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.17	–	–	–	–	[illegible]
155		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Skill 9-10
160		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	Skill 9-10

OPERATION :OFILE

NAME Parker, Philip ALC OC DATE 5/5/89 RCC MAT PCA SHEET 2 OF 2

PCN NSN 38669A WCD CAE M03 ✓ WCD DATE 88239

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
165	MAT PCA	PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY 10	1	1.0	.08	–	–	–	–	Skill 9.10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 05/05/89

ITEM CODE PCN ☒ 38669A NSN. ☐ P/N ☐

WCD CAEM03 WCD DATE 89289

CHART BEGINS Opn # 010

CHART ENDS Opn #

PREPARED BY RJP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC			○▷D□▽	
020	020	○▷D□▽	INFO			○▷D□▽	
025	025	○▷D□▽	INFO			○▷D□▽	
027		○▷D□▽	CLN			○▷D□▽	
030	030	○▷D□▽	INSP			○▷D□▽	
035	035	○▷D□▽	TEST			○▷D□▽	
040	040	○▷D□▽	MACH			○▷D□▽	
045	045	○▷D□▽	DIS			○▷D□▽	
050	050	○▷D□▽	CLN			○▷D□▽	
055	055	○▷D□▽	INSP			○▷D□▽	
060	060	○▷D□▽	TEST			○▷D□▽	
065	065	○▷D□▽	TEST			○▷D□▽	
070	070	○▷D□▽	TEST			○▷D□▽	
075	075	○▷D□▽	TEST			○▷D□▽	
080	080	○▷D□▽	TEST			○▷D□▽	
085	085	○▷D□▽	TEST			○▷D□▽	
090	090	○▷D□▽	ASSY			○▷D□▽	
095	095	○▷D□▽	ASSY			○▷D□▽	
100	100	○▷D□▽	INFO			○▷D□▽	
105	105	○▷D□▽	TEST			○▷D□▽	
110	110	○▷D□▽	WELD			○▷D□▽	
115	115	○▷D□▽	TEST			○▷D□▽	
120	120	○▷D□▽	TEST			○▷D□▽	
123	123	○▷D□▽	TEST			○▷D□▽	
125	125	○▷D□▽	PAINT			○▷D□▽	
130	130	○▷D□▽	TEST			○▷D□▽	
145	145	○▷D□▽	INSP			○▷D□▽	
150	150	○▷D□▽	PW			○▷D□▽	
155	155	○▷D□▽	PW			○▷D□▽	
160	160	○▷D□▽	PW			○▷D□▽	
165	165	○▷D□▽	PW			○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION ?OFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCA SHEET 1 OF 3

FCN/NSN/PN 38694A WCD CAEM09 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	.17	–	–	–	–	SK:ll 9-10
020		INFO	1.0	[redacted]											Applicable Technical Order
				[redacted]											
				[redacted]											
025		INSP	1.0	[redacted]											remove cover, Visual insp.
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN4	1	1.0	.25	SK:ll 9-10
040		ASSY	1.0	[redacted]											replace valve assy.
				[redacted]											
				PROCESS				1	1.0	.25	BEN4	1	1.0	.25	SK:ll 9-10

OPERATION ?ROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 2 OF 3

PCN / NSN / P/N 38694A WCD CAEM09 WCD DATE 88289

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
045	MAT PCA	DIS	.80	[redacted]											80% of all armitures are dished out and must be replaced.
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	.5	BEN4	1	1.0	.5	skill 9-10
055	MAT PIW	WELD	.80	[redacted]											must be sent to welding if armiture removed.
				[redacted]											
				PROCESS	1.0	72.0	–	–	–	–	–	–	–	–	
065	MAT PCA	ASSY	.80	[redacted]											Rebuild armiture and related assy.
				[redacted]											
				PROCESS	–	–	AY10	1	1.0	1.0	BEN4	1	1.0	1.0	skill 9-10
075		TEST	1.0	[redacted]											
				SETUP	–	–		1	1.0	.07	–	–	–	–	
				PROCESS	–	–		1	1.0	.75	OC 6585	1	1.0	.82	skill 9-10
085		ASSY	1.0	[redacted]											reassemble solenoid assembly. This includes safety wiring.
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN4	1	1.0	.25	skill 9-10

LSC-20092C

OPERATION . IOFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PC A SHEET 3 OF 3

NSN
P/N 38694A WCD CAEM09 WCD DATE 89

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
095	MAT PCA	PW	1.0	[redacted]											
				[redacted]											
				PROCESS	-	-	AY10	1	1.0	.25	-	-	-	-	~~SX~~ 11 5-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-2(X)92C

FLOW PROCESS CHART

SUBJECT ______ DATE 5/19/89

ITEM CODE PCN NSN. P/N 38694A

WCD CAEM09 WCD DATE 8829 9

CHART BEGINS 010 —

CHART ENDS 095

PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◇D□▽	REC.			○◇D□▽	
020	020	○◇D□▽	INFO			○◇D□▽	
025	—	○◇D□▽	INSP.			○◇D□▽	
040	040	○◇D□▽	ASSY.			○◇D□▽	
045	—	○◇D□▽	DIS.			○◇D□▽	
055	—	○◇D□▽	WELD.			○◇D□▽	
065	—	○◇D□▽	ASSY.			○◇D□▽	
075	—	○◇D□▽	TEST			○◇D□▽	
085	—	○◇D□▽	ASSY			○◇D□▽	
095	—	○◇D□▽	PW			○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽ ○◇D□▽				○◇D□▽ ○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	
		○◇D□▽				○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION

◇ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME J Carter ALC OC DATE 5/13/89 RCC MAT RCA SHEET __ OF __

PCN/NSN/PIN 38718A WCD CAEM02 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT RCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note: This sheet for IN-OUT Dates

OPERATIOI.. ROFILE

NAME J. CARTER ALC OC PCT DATE 5-3-87 RCC MAT PCA SHEET 1 OF 7

PCN NSN PN 38718A WCD CAE MO2 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC PW	1.00	TRANSIT	—	—	B4 07	—	—	.10	—				
				SETUP	—	—		—	—	—	—	—	—		
				PROCESS	—	—	—	—	—	.10	? BENCH	1	1.0	.1	
020		PW	1.00	TRANSIT	—	—	—	—	—	—	—	—	—	—	
				SETUP	—	—	—	—	—	—	—	—	—	—	
				PROCESS	—	—	—	—	—	.10	? BENCH	1	1.0	1.0	
025		PW	1.00	TRANSIT	—	—	—	—	—			—	—	—	
				SETUP								—	—	—	
				PROCESS						.10	BENCH	1	1.0	.10	
030		PROC	1.00	TRANSIT	—	—									MACHINE SHOP
				SETUP	—	—									
				PROCESS	1.0	24.0		—	—	—	—	—	—	—	
				TRANSIT											
				SETUP											
				PROCESS											

OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT PCA SHEET 2 OF 2

PCN/NSN/P/N 38718A WCD CAEM02 WCD DATE 88235

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
035	MAT PCA	CLEAN	1.0	TRANSIT	—	—									
				SETUP	—	—	—								
				PROCESS	—	—	BY10	1	1.0	.50	BEN?	1	1.0	.50	DEGREASE & SAND BLAST
040		DIS	1.0	TRANSIT	—	—		—	—	—					
				SETUP	—	—		—	—	—					
				PROCESS				1	1.0	.3	BENCH	1	1.0	.30	COMPONANT TEAR DOWN
050		INSP	1.0	TRANSIT								—	—	—	
				SETUP								—	—	—	
				PROCESS	—	—		1	1.0	.10	BENCH	1	1.0	.10	MICKES
060	MAT PCM	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24	—	—	—	—	—	—	—	—	MACHINE SHOP
070	MAT PIW	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24	—	—	—	—	—	—	—	—	WELD

OPERATION . ROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MATPCA SHEET 3 OF 7

PCN / NSN / P/N 38718A WCD CAEM02 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
090	MAT PCM	PROC	1.0	TRANSIT	—	—	—	—	—	—	—	—	—	—	visual disp.
				SETUP	—	—	—	—	—	—	—	—	—	—	micrometer req.
				PROCESS	—	—	BY10	1	1.0	.10	7 ~~BENCH~~	1	1.0	.10	
100	MAT PCA	TEST	1.0	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—			—	—	—	
				PROCESS				—	1.0	.10	7 BENCH	1	1.0	.10	
110		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	—	—	1.0	.05	7 BENCH	1	1.0	.05	
120		PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—			~~1~~	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.02	7 BENCH	1	1.0	.02	
130		TORQUE	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	7 BENCH	1	1.0	.10	

OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT ACA SHEET 4 OF 7

PCN NSN P/N 38718A WCD CAEMD2 WCD DATE 88 23 9

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
140	MAT ACA	PROC	1.0	TRANSIT	—	—			—	—					
				SETUP	—	—		-	—	—					
				PROCESS	-	-	BY10	—	1.0	.10	BEN7	1	1.0	.10	ARBOR PRESS
145	MAT ACM	PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	1.0	4.0	—	—	—	—	—	—	—	—	MACHINE SHOP
150	MAT PIW	PROC	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	2.0									IN FLD SHOP
155	MAT ACA	Ass	1.0	TRANSIT	—			—	—	—		—	—	—	ADDED OPER
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	BY10	1	1.0	1.25	7 BENCH	1	1.0	1.25	
160		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 3906	1	1.0	.10	

OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT/CA SHEET 5 OF 7

PCN/NSN/P/N 38718A WCD CAEM02 ✓ WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
170	MAT RA	TEST	1.0	TRANSIT											COMBINE WITH 160
				SETUP											
				PROCESS											
180		PROC	1.0	TRANSIT											ADD OP 175 .1 HR WELD
				SETUP											
				PROCESS											
190		TEST	1.0	TRANSIT											LEAK & PURGE
				SETUP	—	—		1	1.0	.05		—	—	—	
				PROCESS	1.0	4.75	BY10	1	1.0	.10	OC 2758	1	1.0	4.75	
195		PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	TORQUE
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1.0	1.0	.05	BEN7	1	1.0	.05	
200		TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1.0	1.0	.1	OC 3906	1	1.0	.10	

OPERATIOI. ROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT PCA SHEET 6 OF 7

PCN/NSN/P/N 38718A WCD CAEMO2 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
210	MAT PCA	TEST	1.0	TRANSIT	—	—		—	—	—		—	—	—	SPARK GAP TEST NO #
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	BY 10	1	1.0	.05	OC 4060	—	—	—	
220		CLEAN	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—		1	1	.05	? 13 BENCH	1	1.0	.05	
230		PAINT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	24	—	—	—	—	—	—	—	—	IN 59
240		PROC	1.0	TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	BY 10	1	1	.2	? BENCH	1	1.0	.20	
250		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—		1	1	.05	? BENCH	1	1.0	.05	

OPERATION PROFILE

NAME Carter ALC OC DATE 5/3/89 RCC MAT PCA SHEET 7 OF 7

PCN/NSN/P/N 38718A WCD CAEM02 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
280	MAT PCA	PW	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–	BY10	1	1.0	.10	? BENCH	1	1.0	.10	
270		PW	1.0	TRANSIT	–	–			–	–		–	–	–	
				SETUP	–	–		–	~	–		–	–	–	
				PROCESS	–	–		1	1.0	.05	BENCH	L	1.0	.05	
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	320									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 5/3/89

ITEM CODE PCN ☒ NSN. ☐ P/N ☐ 38718A

WCD CAEM02 WCD DATE 88239

CHART BEGINS 010

CHART ENDS ______ PREPARED BY RJC

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	O ▷ D □ ▽	REC			O ▷ D □ ▽	
020	020	O ▷ D □ ▽	PW			O ▷ D □ ▽	
025	—	O ▷ D □ ▽	PW			O ▷ D □ ▽	
030	030	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
035	—	O ▷ D □ ▽	CLN			O ▷ D □ ▽	
040	040	O ▷ D □ ▽	LIT			O ▷ D □ ▽	
050	050	O ▷ D □ ▽	INSP			O ▷ D □ ▽	
060	060	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
070	070	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
090	090	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
100	100	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
110	110	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
120	120	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
130	130	O ▷ D □ ▽	TORQUE			O ▷ D □ ▽	
140	140	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
145	145	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
150	150	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
155	—	O ▷ D □ ▽	ASSY			O ▷ D □ ▽	
160	160	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
170	170	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
180	180	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
190	190	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
195	195	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
200	200	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
210	210	O ▷ D □ ▽	TEST			O ▷ D □ ▽	
220	220	O ▷ D □ ▽	CLN			O ▷ D □ ▽	
230	230	O ▷ D □ ▽	PAINT			O ▷ D □ ▽	
240	240	O ▷ D □ ▽	PROC			O ▷ D □ ▽	
250	250	O ▷ D □ ▽	PW			O ▷ D □ ▽	
260	260	O ▷ D □ ▽	PW			O ▷ D □ ▽	
270	270	O ▷ D □ ▽	PW			O ▷ D □ ▽	
		O ▷ D □ ▽				O ▷ D □ ▽	

O OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME Packer ALC OC DATE 5/E/89 RCC MAT PCA SHEET - OF -

PCN 49711A WCD CAECO7 WCD DATE 89045

~~NSN~~
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
1.0	MAT PCA	IN	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	24.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: This sheet for IN-OUT DATES

OPERATION PROFILE

NAME Packer ALC OC DATE 5/8/89 RCC MAT PCA SHEET 1 OF 10

PCN/NSN/PN 49711A WCD CAFC07 WCD DATE F9095

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY 10	1	1.0	.03	BEN2	1	2.0	.03	skill 9-10
015		INFO	1.0	[redacted]											
				[redacted]											
				[redacted]											skill 9-10
018		TEST	1.0	[redacted]											as per T.O.: [illegible]
				SETUP	–	–		1	1.0	.03	–	–	–	–	[illegible]
				PROCESS	–	–		1	1.0	.03	OC 4929	1	1.0	4	50% [illegible]
020	MAT PCM	MACH	.50	[redacted]											See MAT PCM notes for info on this opn. ([illegible])
				[redacted]											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	skill 9-10
030	MAT PCA	VIS	.50	[redacted]											
				[redacted]											
				PROCESS	–	–	BY 10	1	1.0	.15	BEN2	1	1.0	.15	skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/18/89 RCC MAT PCA SHEET 2 OF 10

PCN/NSN/PIN 49711A WCD CAEC07 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	CLN	.50	~~TRANSIT~~											
				SETUP											
				PROCESS	–	–	BY10	1	1.0	.08	BEN32	1	1.0	.08	Skill 9-10
050		INSP	.50	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.03	BEN2	1	1.0	.03	Skill 9-10
051		INSP	.50	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.03	BEN 2	1	1.0	.03	Skill 9-10
053		ASSY	.50	~~TRANSIT~~											added - sand edges
				SETUP											
				PROCESS	–	–		1	1.0	.07	BEN2	1	1.0	.07	Skill 9-10
055	MAT PIW	WELD	.50	~~TRANSIT~~											Housing to welding for add. of extension strips. Note: If housing must be extended must remove capacitor. (Problem with fumes).
				~~SETUP~~											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	

OPERATION . ROFILE

NAME Parker ALC OC DATE 5/18/89 RCC MATPCA SHEET 3 OF 10

NSN 49711A WCD CAECO7 WCD DATE 59098

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
060	MAT PCA	TEST	.50	TRANSIT											
				SETUP											
				PROCESS	—	—	BY10	1	1.0	.02	BEN2	1	1.0	.02	Skill 5-10
065	MAT PCM	MACH	.50	TRANSIT											This opn required only 5% of the time dependent on results of opns 80 & 90
				SETUP											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	
070	MAT PIW	WELD	.03	TRANSIT											This opn required only 5% of the time dependent on results of opns 80 & 90
				SETUP											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	
080	MAT PCA	TEST	.03	TRANSIT											capacitor analyzer OC # 4060
				SETUP											
				PROCESS	—	—	BY10	1	1.0	.08	OC # 4060	1	1.0	.08	Skill 9-10
090		TEST	.50	TRANSIT											Req 400 V megger. Not available. Must use test stand.
				SETUP	—	—		1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.08	OC # 5507	1	1.0	.16	Skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 4 OF 10

PCN 49711A WCD CAECO7 WCD DATE 89094

PN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCA	TEST	.50	TEARDOWN											use ohm meter
				SETUP											
				PROCESS	—	—	BY10	1	1.0	.02	BEN 2	1	1.0	.02	SKill 9-10
110		TEST	.50	TEARDOWN											
				SETUP											
				PROCESS	—	—		1	1.0	.02	BEN 2	1	1.0	.02	SKill 9-10
120		TEST	.50	TEARDOWN											
				SETUP	—	—		1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.08	OC # 4060	1	1.0	.16	SKill 9-10
130		TEST	.50	TEARDOWN											[illegible] 2 min
				SETUP											
				PROCESS	—	—		1	1.0	.08	BEN 2	1	1.0	.08	SKill 9-10 70% failure
140		TEST	.50	TEARDOWN											
				SETUP											
				PROCESS	—	—		1	1.0	.08	BEN 2	1	1.0	.08	SKill 9-10

LSC-2(X)92C

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 5 OF 10

PCN NSN PN 49711A WCD CAEC07 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCA	TEST	.50	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.08	BENZ	1	1.0	.08	
160		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.08	BENZ	1	1.0	.08	SKill 9-10
170		DIS	.50	[redacted]											capacitor repaired in unit.
				[redacted]											must be placed in ...
				PROCESS	1.0	24.0		1	1.0	.80	OC 2758	1	1.0	11.5	SKill 9-10
175		TEST	.50	[redacted]											SKill 9-10
				SETUP	—	—		1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.08	OC # 4060	1	1.0	.16	Test stand OC # : 4060
180		TEST	.50	[redacted]											Test stand: OC # 4060
				SETUP	—	—		1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.12	OC # 4060	1	1.0	.20	SKill 9-10

LSC-2(X)92C

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 6 OF 10

PCN NSN P/N 49711A WCD CAEC07 WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
190	MAT PCA	TEST	.50	[redacted]											Spik gap oc # 3506
				SETUP	—	—	BY10	1	1.0	.03	—	—	-	—	
				PROCESS	—	—		1	1.0	.02	OC 3906	1	1.0	.05	SKill 9-10
195		TEST	.50	[redacted]											
				SETUP				1	1.0	.02	—	—	—	—	
				PROCESS	—	—		1	1.0	.02	BEN15	1 —	1.0 —	.04	SKill 9-10
200		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.02	BEN2	1	1.0	.02	SKill 9-10
203		TEST	.50	[redacted]											adapted test due to lack of 7.0 special equip.
				SETUP	—	—		1	1.0	.02	—	—	+	—	
				PROCESS	—	—		1	1.0	.08	OC # 3953	1	1.0	.10	SKill 9-10
205	MAT PCM	MACH	.35	[redacted]											will chk back test in mach. 70% Failure rate.
				[redacted]											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	

OPERATION PROFILE

NAME Parker ALC OC DATE 05/18/89 RCC MAT PCA SHEET 2 OF 10

FCN/NSN/PN 49711A WCD CAFC07 WCD DATE 89095

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
207	MAT PCA	PROC	.35	~~TRANSPORT~~											
				~~SETUP~~											
				PROCESS	—	—	BY10	1	1.0	.07	BEN2	1	1.0	.07	SK:11 9-10
208	MAT PIW	WEID	.35	~~TRANSPORT~~											
				~~SETUP~~											
				PROCESS	1.0	240	—	—	—	—	—	—	—	—	
209	MAT PCA	Test	.50	~~TRANSPORT~~											Tested due to sign. failure intcs
				SETUP	—	—	BY10	1	1.0	.05	—	—	—	—	
				PROCESS	—	—		1	1.0	.03	OC#4060	1	1.0	.08	SK:11 9-10
210		ASSY	.50	~~TRANSPORT~~											Repair and replace AS Arc.
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.50	BEN2	1	1.0	.50	SK:11 9-10
230		ASSY	.50	~~TRANSPORT~~											
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.50	BEN2	1	1.0	.50	SK:11 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MATALA SHEET 8 OF 10

PCN/NSN/PN 49711A WCD CAEC07 ✓ WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
240	MAT PCA	PROC	.50	TRANSIT											Drying in oven
				SETUP	-	-	BV10	1	1.0	.05	-	-	-	-	
				PROCESS	1.0	4.75		1	1.0	.10	OC # 2758	1	1.0	4.75	Skill 9-10
250		PROC	.50	TRANSIT											fill with resin
				SETUP											
				PROCESS	-	-		1	1.0	.18	BEN2	1	1.0	.18	Skill 9-10
260		PROC	.50	TRANSIT											Baking in oven
				SETUP	-	-		1	1.0	.05	-	-	-	-	
				PROCESS	1.0	4.75		1	1.0	.10	OC # 2758	1	1.0	4.75	Skill 9-10
265		Test	.50	TRANSIT											
				SETUP	-	-		1	1.0	.03	-	-	-	-	
				PROCESS	-	-		1	1.0	.03	OC # 3906	1	1.0	.06	Skill 9-10
270	MAT PIW	WELD	.50	TRANSIT											
				SETUP											
				PROCESS	1.0	24.0	-	-	-	-	-	-	-	-	

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 9 OF 10

PCN/NSN/P/N 49711A WCD CAECO2 WCD DATE 8909 5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
295	MAT PCA	PROC	.50	[redacted]											oven
				[redacted]											apply vacuum and heat.
				PROCESS	1.0	.5	BY10	1	1.0	.02	OC# 2758	1	1.0	.5	Skill 5-10
300		PROC	.50	[redacted]											No SSS pressurized
				[redacted]											and continue to heat
				PROCESS	1.0	3.0		1	1.0	.02	OC# 2758	1	1.0	3.0	skill 9-10
305		TEST	.50	[redacted]											Test before paint.
				[redacted]											If done after and test fails, must sand blast paint off.
				PROCESS	–	–		1	1.0	.03	BEN 17 [redacted]	1	1.0	.03	skill 9-10
310		PAINT	.50	[redacted]											Paint plus primer.
				[redacted]											2 hr. drying time
				PROCESS	1.0	2.0	B307	1	1.0	.30	WB52	1	1.0	.30	Skill WG-7
340		TEST	.50	[redacted]											Ohmmeter reg.
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.03	BEN	1	1.0	.03	Skill 5-10

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 10 OF 10

PCN/NSN/PHI 49711A WCD CAECO7 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
350	MAT PCA	TEST	1.0	[redacted]											
				SETUP	—	—	BY10	1	1.0	.03	—	—	—	—	
				PROCESS	—	—		1	1.0	.03	OC # 3906	1	1.0	.06	Skill 9-10
360		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.17	—	—	—	—	Skill 9-10
370		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.02	—	—	—	—	Skill 9-10
380		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.02	—	—	—	—	Skill 9-10
385		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.02	—	—	—	—	Skill 9-10
9999		out	1.0	Process	1.0	48.0									

FLOW PROCESS CHART

SUBJECT ______ DATE 05/02/89

ITEM CODE
PCN ☒ 49711A
NSN. ☐
P/N ☐

WCD CAECO7 WCD DATE 89045 —

CHART BEGINS 010 —

CHART ENDS 385

PREPARED BY ______

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○◇D□▽	REC	209	—	○◇D□▽	TEST
015	015	○◇D□▽	INFO	210	210	○◇D□▽	ASSY
018	—	○◇D□▽	TEST	230	230	○◇D□▽	ASSY
020	020	○◇D□▽	MACH	240	240	○◇D□▽	PROC
030	030	○◇D□▽	DIS	250	250	○◇D□▽	PROC
040	040	○◇D□▽	CIN	260	260	○◇D□▽	PROC
050	050	○◇D□▽	INSP	265	—	○◇D□▽	TEST
051	051	○◇D□▽	INSP	270	270	○◇D□▽	WELD
053	—	○◇D□▽	ASSY	275	—	○◇D□▽	PROC
055	055	○◇D□▽	WELD	300	300	○◇D□▽	PROC
060	060	○◇D□▽	TEST	305	—	○◇D□▽	TEST
065	—	○◇D□▽	MACH	310	310	○◇D□▽	Paint
070	070	○◇D□▽	WELD	340	340	○◇D□▽	TEST
080	080	○◇D□▽	TEST	350	350	○◇D□▽	TEST
090	090	○◇D□▽	TEST	360	360	○◇D□▽	PW
100	100	○◇D□▽	TEST	370	370	○◇D□▽	PW
110	110	○◇D□▽	TEST	380	380	○◇D□▽	PW
120	120	○◇D□▽	TEST	385	385	○◇D□▽	PW
130	130	○◇D□▽	TEST			○◇D□▽	
140	140	○◇D□▽	TEST			○◇D□▽	
150	150	○◇D□▽	TEST			○◇D□▽	
160	160	○◇D□▽	TEST			○◇D□▽	
170	170	○◇D□▽	DIS			○◇D□▽	
175	—	○◇D□▽	TEST			○◇D□▽	
180	180	○◇D□▽	TEST			○◇D□▽	
190	190	○◇D□▽	TEST			○◇D□▽	
195	195	○◇D□▽	TEST			○◇D□▽	
200	200	○◇D□▽	TEST			○◇D□▽	
203	—	○◇D□▽	TEST			○◇D□▽	
205	—	○◇D□▽	MACH			○◇D□▽	
207	—	○◇D□▽	PROC			○◇D□▽	
208	—	○◇D□▽	WELD			○◇D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
◇ TRANSPORTATION D DELAY

OPERATION PROFILE

NAME Parker ALC OC DATE 5/09/89 RCC MAT PCA SHEET – OF –

PCN/NSN/P/N 50078 A WCD CAEZ05 WCD DATE 88204

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	8.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: THIS SHEET FOR IN-OUT DATES

LSC-20092C

OPERATIO... ROFILE

NAME Pa... ALC ... DATE ... RCC ... SHEET 1 OF 6

PCN
NSN
P/N 50078A

WCD ... WCD DATE 820

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
003	MAT PAC	PROC	1.0	[redacted]											sandblast ... trolly
				[redacted]											
				PROCESS	–	–	BY 07	1	1.0	.25	OC3965	1	1.0	.25	Sk... ...6-7
005		PW	1.0	[redacted]											Do ... ... put ... computer.
				[redacted]											
				PROCESS	–	–	BY 0	1	1.0	.08	–	–	–	–	Sk... ...-10
010		REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.25	BEN4	1	1.0	.25	Sk... 9-10
015		INFO	1	[redacted]											
				[redacted]											
				[redacted]											Sk... 9-10
020		TEST	1.0	[redacted]											Skill 9-10
				SETUP	–	–		1	1.0	.08	–	–	–	–	
				PROCESS	–			1	1.0	.17	OC 3906	1	1.0	.25	

LSC-20092C

OPERATIO.. PROFILE

NAME [illegible] ALC [illegible] DATE RCC [illegible] SHEET [illegible] OF 6

PCN NSN P/N 500784 WCD [illegible] WCD DATE 8820

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
030	MAT PCA	INFO	.10	[illegible]											Repair as necessary see 1.0 reference
				[illegible]											
				[illegible]											
[illegible]		DIS	.10	TRANSIT											
				SETUP											
				PROCESS	-	-	CY10	1	1.0	.25	BEN4	-	-	-	SK.11 5-10
050		CLN.	.10	TRANSIT											
				SETUP											
				PROCESS				1	1.0	1.0	BEN4	1	1.0	1.0	SK... 5-10
060		INSP	.10	TRANSIT											Visual
				SETUP											
				PROCESS						.25	BEN4	1	1.0	.25	SK.11 5-10
070		TEST	.10	TRANSIT											Also use the portable capacitance analyzer.
				SETUP				1	1.0	.25	-	-	-	-	
				PROCESS				1	1.0	.25	OC 3952	1	1.0	1.0	SK... 5-10

OPERATIOI. . ROFILE

NAME Parker ALC OC DATE 0_/__/89 RCC MAT PCA SHEET 3 OF 6

PCN/NSN/PIN 50078A WCD CAEZOS WCD DATE 8820 [illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
250	MAT PCA	ASSY	.10	[illegible]											
				[illegible]											
				PROCESS	–	–	BY10	1	1.0	.25	BEN4	1	1.0	.25	Skill 9-10
281		INSP	.10	[illegible]											[illegible]
				[illegible]											
				PROCESS	–	–		1	1.0	.03	BEN4	1	1.0	.03	Skill 9-10
282		PROC	.10	[illegible]											[illegible] contro[illegible] [illegible] (30 hrs).
				[illegible]											
				PROCESS	1.0	30		–	–						Skill 9-10
290		ASSY	.10	[illegible]											
				[illegible]											
				PROCESS	–	–		1	1.0	1.0	BEN4	1	1.0	1.0	Skill 9-10
295		PROC	.10	[illegible]											
				[illegible]											
				PROCESS	–	–		1	1.0	.50	BEN4	1	1.0	.50	Skill 9-10

OPERATIO.. PROFILE

NAME Parker ALC ?C DATE ______ RCC ______ SHEET 1 OF 6

PCN / NSN / P/N 5 ... 8 A...

WCD CAI Z... WCD DATE 8820

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
310	MAT (KA	INSP	.10	[redacted]											Skill 5-10
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.03	BEN 17	1	1.0	.05	
370		PROC	.1	[redacted]											(Heat)
				[redacted]											
				PROCESS	1.0	.50		1	1.	.05	OC 2758	1	1.0	.55	Skill 5-10
380		PROC	.1	[redacted]											(Heat)
				[redacted]											
				PROCESS	1.0	4.0				.02	OC 2758	1	1.0	4.2	Skill 5-10
390		PROC	.1	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.03	BEN 4	1	1.0	.03	Skill 5-10
400		PROC	.10	[redacted]											handling, cool
				[redacted]											
				PROCESS		8.0		1	1.0	.02	BEN 4	1	1.0	.02	Skill 5-10

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/ /89 RCC A A SHEET 5 OF 6

PCN NSN P/N S0078A WCD CAF ZOS WCD DATE

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
410	MAT PCA	INSP	.10	[redacted]											Solder
				[redacted]											
				PROCESS	–	–	B			.08	BEN4	1	1.0	.08	Skill 9-1
420		TEST	.10	[redacted]											Final functional test.
				SETUP	–	–		1	1.0	.08					
				PROCESS	–	–		1	1.0	.17	OC 3906	1	1.0	.25	Skill 9-10
425		PAINT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.30	W59	1	1.0	.30	Skill WG-7
430		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	-	-	BY10	1	1.0	.08	–	–	–	-	Skill 9-10
440		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	-	-		1	1.0	.03	–	–	-	-	Skill 9-10

LSC-20092C

OPERATIO.. ROFILE

NAME Parker ALC OC DATE 051 RCC MATPCA SHEET – OF 6

(PCN) NSN P/N 50028A WCD CAEZ05 ✓ WCD DATE 89094

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
450	MAT PCA	PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.08	–	–	–	–	Skill 9-10
460		PW	1.0	[redacted]											specification of tasks on this pg
				[redacted]											
				PROCESS	–	–		1	1.0	.08	–	–	–	–	Skill 9-10
485		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–		–	–	Skill 9-10
490		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	10	.08	–		–	–	Skill 9-10
4999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	6.0									

LSC-20092C

FLOW PROCESS CHART

SUBJECT ______ DATE 5/5/89

ITEM CODE
PCN ☒ 500784
NSN ☐
P/N ☐

WCD CAEZ 05 WCD DATE 89094

CHART BEGINS 003

CHART ENDS 490

PREPARED BY ______

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
003	—	○▷D□▽	Sandblast			○▷D□▽	
005	005	○▷D□▽	PW			○▷D□▽	
010	010	○▷D□▽	REC			○▷D□▽	
015	015	○▷D□▽	INFO			○▷D□▽	
020	020	○▷D□▽	TEST			○▷D□▽	
030	030	○▷D□▽	INFO			○▷D□▽	
040	040	○▷D□▽	DIS			○▷D□▽	
050	050	○▷D□▽	CLN			○▷D□▽	
060	060	○▷D□▽	INSP			○▷D□▽	
070	070	○▷D□▽	TEST			○▷D□▽	
250	250	○▷D□▽	ASSY			○▷D□▽	
281	281	○▷D□▽	INSP			○▷D□▽	
282	282	○▷D□▽	PROC			○▷D□▽	
290	290	○▷D□▽	ASSY			○▷D□▽	
295	295	○▷D□▽	PROC			○▷D□▽	
310	310	○▷D□▽	INSP			○▷D□▽	
320	320	○▷D□▽	PROC			○▷D□▽	
380	380	○▷D□▽	PROC			○▷D□▽	
390	390	○▷D□▽	PROC			○▷D□▽	
400	400	○▷D□▽	PROC			○▷D□▽	
410	410	○▷D□▽	INSP			○▷D□▽	
420	420	○▷D□▽	TEST			○▷D□▽	
425	425	○▷D□▽	PAINT			○▷D□▽	
430	430	○▷D□▽	PW			○▷D□▽	
440	440	○▷D□▽	PW			○▷D□▽	
450	450	○▷D□▽	PW			○▷D□▽	
460	460	○▷D□▽	PW			○▷D□▽	
485	485	○▷D□▽	PW			○▷D□▽	
490	490	○▷D□▽	PW			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC 0:: DATE 5/16/89 RCC MAT PCA SHEET - OF -

(PCN) NSN P/N 50217A WCD CAEA01 ✓ WCD DATE 86121

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	36.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: This sheet is for IN-OUT Sheet

LSC-20092C

OPERATION ROFILE

NAME Parker ALC OC DATE 5/1, 87 RCC MAT PCA SHEET 1 OF 4 ... daughn

PCN/NSN/PRI 50217A WCD CAEA01 ✓ WCD DATE 8612

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.08	BEN6	1	1.0	.08	Skill 5-10
015		INFO	1.0	[redacted]											Applicable T.O.
				[redacted]											
				[redacted]											
017		PROC	1.0	TRANSIT											Sandblast
				SETUP											
				PROCESS	–	–	BY07	1	1.0	.12	or 3565	1	1.0	.12	... wo ...
018		TEST	1.0	[redacted]											60% Failure rate.
				SETUP	–	–		1	1.0	.12			–	–	
				PROCESS	–	–	BY10	1	1.0	.08	OC 3906	1	1.0	.20	Skill 9-10
020		REP	.30	[redacted]											Transformer fails 50% of tests (visual and/or electrical). Time includes remove and replace.
				[redacted]											
				PROCESS	–	–		1	1.0	4.5	BEN6	1	1.0	4.5	Skill 5-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATPCA SHEET 2 OF 4

PCN / NSN / PRI 502I7A WCD CAEA01 WCD DATE 86198

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
021	MAT PCA	TEST	.60	[redacted]											Tube assy. are defective in approx. 50% of all items failing test.
				SETUP	–	–		1	1.0	.33	–	-	-	-	
				PROCESS	–	–	BY10	1	1.0	.10	BEN 15	1	1.0	.43	skill 9-10
022		REP	.30	[redacted]											[illegible] and replace tube assy.
				[redacted]											
				PROCESS	–	–		1	1.0	.75	BEN 1	1	1.0	.75	skill 9-10
023		REP	.12	[redacted]											Rectifier defective in ~ 20% of all items failing test. (Tube assy. must be removed).
				[redacted]											
				PROCESS	–	–		1	1.0	.50	BEN 6	1	1.0	.50	skill 9-10
024		REP	.03	[redacted]											capacitor No. one defective ~ 5% of all failed items.
				[redacted]											
				PROCESS	–	–		1	1.0	1.0	BEN 6	1	1.0	1.0	skill 9-10
025		REP	.03	[redacted]											capacitor assy #2 defective in ~ 5% of all failed items
				[redacted]											
				PROCESS	–	–		1	1.0	2.0	BEN 6	1	1.0	2.0	skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 3 OF 4

PCN / NSN / PNI 50217A

WCD CAEA01 WCD DATE 86/[illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	INSP	.60	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.08	BEN6	1	1.0	.08	SK[illegible] 5-10
085		TEST	.60	~~TRANSIT~~											before sealing
				SETUP	–	–		1	1.0	.12	–	–	–	–	see [illegible] OK
				PROCESS	–	–		1	1.0	.08	OC 3906	1	1.0	.20	
360		ASSY	.60	~~TRANSIT~~											[illegible] press and closed [illegible] der
				~~SETUP~~											
				PROCESS	1	1.0		1	1.0	1.0	BEN6	1	1.0	1.0	SK[illegible] 5-10
405		Insp	.60	[redacted]											Lock ck [illegible]
				[redacted]											
				PROCESS	–	–		1	1.0	.03	BEN17	1	1.0	.03	SK[illegible] 5-10
435		PROC	.60	~~TRANSIT~~											includes cooling [illegible]
				~~SETUP~~											
				PROCESS	1.0	2.5		1	1.0	.02	OC 2758	1	1.0	2.52	[illegible]

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/85 RCC MAT PCA SHEET 4 OF 4

PCH / RSN / PMI 50217A WCD CAEA01 ✓ WCD DATE 86198

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
460	MAT PCA	TEST	.60	TR[redacted]											spark gap machine
				SETUP	—	—		1	1.0	.03					
				PROCESS	—	—	BY10	1	1.0	.05	OC 4060	1	1.0	.08	Skill -10
470		TEST	.60	[redacted]											
				SETUP	—	—		1	1.0	.12					
				PROCESS	—	—		1	1.0	.08	OC 3906	1	1.0	.20	Skill 9-10
490		TEST	.60	[redacted]											second part of test
				SETUP				1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.03	OC 3906	1	1.0	.11	Skill 9-10
499		PAINT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.30	W59	1	1.0	.30	Skill 9-10
547		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.11	—	—	—	—	Skill 9-10
9999		OUT	1.0	Process	1.0	0									

LSC-2000-2C

OPERATION PROFILE

NAME Packer ALC OC DATE 5/19/89 RCC MATPCA SHEET 2 OF 4

PCN / NSN / PN 502927A WCD CAEM22 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
045	MAT PCA	DIS	.05	[redacted]											deburr, dis.
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.58	BEN 4	1	1.0	.58	Skill 9-10
060		TEST	.05	[redacted]											Tube tester
				SETUP	–	–		1	1.0	.03	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	BEN 15	1	1.0	.06	Skill 9-10
079		TEST	.05	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.17	BEN 4	1	1.0	.17	Skill 9-10
090		ASSY	.05	[redacted]											remove and replaced as necessary, reassy.) torque
				[redacted]											
				PROCESS	–	–		1	1.0	1.17	BEN 4	1	1.0	1.17	Skill 9-10
105		TEST	.05	[redacted]											Identical to opn #035.
				SETUP	–	–		1	1.0	.07	–	–	–	–	
				PROCESS	–	–		1	1.0	.07	α # 3906	1	1.0	.14	Skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCA SHEET 3 OF 4

PCN/NSN/PN 50297A WCD CAEM 22 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
110	MAT PIW	WELD	.05	[redacted]											
				[redacted]											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	
115	MAT RA	INSP	.05	[redacted]											Fill dry N_2, water bath
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.03	BEN4	1	1.0	.03	Skill 5-10
120		PROC	.05	[redacted]											Bake in oven, Vacume (dry).
				[redacted]											
				PROCESS	1.0	4.25				.03	BEN 4	1	1.0	.03	Skill 5-10
121		INSP	.05	[redacted]											water bath
				[redacted]											
				PROCESS	1	1.0		1	1.0	.05	BEN4	1	1.0	.05	Skill 5-10
122		TEST	.05	[redacted]											Same as opn # 35
				SETUP	–	–		1	1.0	.07	–	–	–	–	
				PROCESS	–	–		1	1.0	.07	OC E 3906	1	1.0	.14	Skill 5-10

OPERATION ?OFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCA SHEET 4 OF 4

PCN
NSN
P/N 50297A WCD CAEM22 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
123	MAT PCA	PROC	.05	[redacted]											Sand blast
				[redacted]											
				PROCESS	-	-	BY07	1	1.0	.25	BEN 4	1	1.0	.25	Skill WG-07
125		PAINT	1.0	[redacted]											
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.30	W59	1	1.0	.30	Skill WG-07
147		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	-	-	BY10	1	1.0	.17	-	-	-	-	Skill 9-10
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	9.6									
				TRANSIT											
				SETUP											
				PROCESS											

LSC-2000?C

FLOW PROCESS CHART

SUBJECT ______________________ DATE 5/19/89

ITEM CODE
PCN ☒ 50297A
NSN ☐
P/N ☐

WCD CAEM22 WCD DATE 88239

CHART BEGINS 010

CHART ENDS 147 PREPARED BY CJP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC.			○▷D□▽	
020	020	○▷D□▽	INFO			○▷D□▽	
030	030	○▷D□▽	INSP			○▷D□▽	
035	035	○▷D□▽	TEST			○▷D□▽	
040	040	○▷D□▽	MACH.			○▷D□▽	
045	045	○▷D□▽	DIS			○▷D□▽	
060	060	○▷D□▽	TEST			○▷D□▽	
079	–	○▷D□▽	TEST			○▷D□▽	
090	090	○▷D□▽	ASSY.			○▷D□▽	
105	105	○▷D□▽	TEST			○▷D□▽	
110	110	○▷D□▽	WELD.			○▷D□▽	
115	115	○▷D□▽	INSP			○▷D□▽	
120	120	○▷D□▽	PROC			○▷D□▽	
121	–	○▷D□▽	INSP			○▷D□▽	
122	–	○▷D□▽	TEST			○▷D□▽	
123	–	○▷D□▽	Proc.			○▷D□▽	
125	125	○▷D□▽	Paint			○▷D□▽	
147	–	○▷D□▽	PW			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATIO' 'ROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET – OF –

PCN
NSN 61234A
PN

WCD CAECOS ✓ WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
							SKILL CODE/ LEVEL	QTY.	TIME REQUIRED		EQUIPMENT CODE	QTY.	TIME REQUIRED		
					%	HRS.			%	HRS.			%	HRS.	
				TRANSIT											
00	MAT PCA	IN	1.0	SETUP											
				PROCESS	1.0	206									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: This sheet for IN-OUT DATES

OPERATIO[illegible] PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 1 OF 4

PCN/NSN/PIN 61234A WCD CAEC05 WCD DATE 89[illegible]5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	TRANSIT											
				SETUP											
				PROCESS	—	—	BY10	1	1.0	.08	BEN4	2	1.0	.08	Skill 5-10
015		INFO	1.0	TRANSIT											Applicable T.O.
				SETUP											
				PROCESS											
017		PROC	1.0	TRANSIT											Sandblast
				SETUP											
				PROCESS	—	—	BY07	1	1.0	.12	OC3965	1	1.0	.12	Skill WG-?
018		TEST	1.0	TRANSIT											60% Failure rate.
				SETUP	–	–		1	1.0	.12	–	–	–	—	
				PROCESS	—	—	BY10	1	1.0	.08	OC 3906	1	1.0	.20	Skill 9-10
020		REP	.30	TRANSIT											Transformer fails 50% of tests visual and/or electr.
				SETUP											Time includes remove and replace.
				PROCESS	—	—		1	1.0	4.5	BEN [illegible]	1	1.0	4.5	Skill 5-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MATPCA SHEET 2 OF 4

PCN / NSN / P/N 61234A WCD CAECOS WCD DATE 8[illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
021	MAT PCA	TEST	.30	~~TRANSIT~~											Tube assy. are defective in approx. 50% of all items fail test.
				SETUP	–	–		1	1.0	.33	–	–	–	–	
				PROCESS	–	–	BY10	1	1.0	.10	BEN 15 ~~[illegible]~~	1	1.0	.43	Skill 9-10
022		REP	.30	~~TRANSIT~~											Remove and replace tube assy.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.75	BEN4	1	1.0	.75	Skill 9-10
023		REP	.12	~~TRANSIT~~											Rectifier defective in ~ 20% of all items failing test. (Tube assy. must be rem
				~~SETUP~~											
				PROCESS	–	–		1	1.0	.50	BEN4	1	1.0	.50	Skill 9-10
024		REP	.03	~~TRANSIT~~											Capacitor No. one defective ~ 5% of all failed items.
				~~SETUP~~											
				PROCESS	–	–		1	1.0	1.0	BEN4	1	1.0	1.0	Skill 9-10
025		REP	.03	~~TRANSIT~~											Capacitor assy #2 defective in ~ 5% of all failed items
				~~SETUP~~											
				PROCESS	–	–		1	1.0	2.0	BEN4	1	1.0	2.0	Skill 9-10

OPERATIC.. PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 3 OF 4

PCH
NSN
PN 61234A

WCD CAECOS ✓ WCD DATE 89[illegible]5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	INSP	.60	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	—	—	BY10	1	1.0	.08	BEN4	1	1.0	.08	Skill 5-13
085		TEST	.60	~~TRANSIT~~											before sealing
				SETUP	—	?		1	1.0	.12	—	—	—	—	see opn 018
				PROCESS	—	—		1	1.0	.08	OC 3906	1	1.0	.20	
360		ASSY	.60	~~TRANSIT~~											case reassy and closed solder
				~~SETUP~~											
				PROCESS	1	1.0		1	1.0	1.0	BEN4	1	1.0	1.0	Skill 5-13
405		Insp	.60	~~TRANSIT~~											Leak ck water
				~~SETUP~~											
				PROCESS	—	—		1	1.0	.03	BEN17	1	1.0	.03	Skill 5-13
435		PROC	.60	TRANSIT											includes cooling [illegible]
				~~SETUP~~											
				PROCESS	1.0	2.5		1	1.0	.02	OC 2758	1	1.0	2.52	Skill 5-13

OPERATIC' PROFILE

NAME Parker ALC OC DATE 5/16/89 RCC MAT PCA SHEET 4 OF 4

PCN/NSN/PNI 61234A

WCD CAECOS WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
460	MAT PCA	TEST	.60	~~TRANSIT~~											spark gap machine
				SETUP	–	–		1	1.0	.03					
				PROCESS	–	–	BY10	1	1.0	.05	OC 4060	1	1.0	.08	Skill [illegible]-10
470		TEST	.60	~~TRANSIT~~											
				SETUP	–	–		1	1.0	.12					
				PROCESS	–	–		1	1.0	.08	OC 3906	1	1.0	.20	Skill 9-10
490		TEST	.60	~~TRANSIT~~											second part of test
				SETUP				1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC 3906	1	1.0	.11	Skill 9-10
499		PAINT	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	1.0	2.0	6307	1	1.0	.30	W59	[illegible]	1.0	.30	Skill 9-10
547		PW	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.11	–	–	–	–	Skill 9-10
9999		OUT	1.0	Process	1.0	6.9									

LSC-20092C

FLOW PROCESS CHART

SUBJECT ____ DATE 5/16/89

ITEM CODE: PCN ☒ NSN ☐ P/N ☐

WCD CAEC05 WCD DATE 89085

CHART BEGINS 010

CHART ENDS ____ PREPARED BY MP

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○	REC				
015	015	○	INFO				
017	–	○	Sandblast				
018	–	□	TEST				
020	020	○	REP.				
021	–	□	TEST				
022	–	○	REP				
023	–	○	REP				
024	–	○	REP				
025	–	○	REP				
040	040	□	INSP				
085	–	□	TEST				
360	360	○	ASSY				
405	–	□	INSP				
435	–	○	PROC				
460	460	□	TEST				
470	470	□	TEST				
490	490	□	TEST				
495	459	○	PAINT				
547	547	○	PW				

○ OPERATION ▽ STORAGE □ INSPECTION

▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MAT PCA SHEET - OF -

PCN/NSN/PNI 97133A WCD CAEB08 WCD DATE 89033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT RCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	480									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

Note: This sheet for in-out dates.

LSC-200920

OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 1 OF 3

wendel Hawkins

PCH NSN 97133A WCD CAEB08 WCD DATE 89038

PN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MAT PCA	REC	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.08	BEN4	1	1.0	.08	SKill 5-10
015		INFO	1.0	[redacted]											
				[redacted]											
				[redacted]S											Skill 5-10
020		DIS	1.0	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.25	BEN4	1	1.0	.25	Skill 5-10
030		CLN	1.0	T[redacted]											Precon Task Remove carbon, etc. Hand brush.
				[redacted]											
				PROCESS				1	1.0	.8	BEN4	1	1.0	.25	Skill 5-10
040		INSP	1.0	[redacted]											visual insp.
				[redacted]											
				PROCESS				1	1.0	.05	BEN4	1	1.0	.05	Skill 5-10

OPERATION PROFILE

NAME Parker ALC OC DATE 05/19/89 RCC MAT PCA SHEET 2 OF 3

PCH/NSN/PN 97133A WCD CAEBO8 WCD DATE 89033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
070	MAT PCA	TEST	1.0	[redacted]											Coil tested Dielectric tester
				PROCESS	–	–	BY10	1	1.0	.17	BEN4	1	1.0	.17	skill 9-10
090	MAT PCM	MACH	.15	[redacted]											Housing cracked. (15% occurrence)
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	
155	MAT PCA	ASSY	1.0	[redacted]											This delayed by about if above occurs, otherwise 100%
				PROCESS	–	–	BY 10	1	1.0	1.0	BEN4	1	1.0	1.0	skill 9-10
205		TEST	1.0	[redacted]											Added Test - Apply air to check for leaks. Important procedure. Needed to avoid delays.
				PROCESS	–	–		1	1.0	.08	BEN4	1	1.0	.08	
255		TEST	1.0	[redacted]											Tested in Bldg. 3108 by technician doing overhaul.
				SETUP	–	–		1	1.0	.50	–	–	–	–	
				PROCESS	–	–		1	1.0	.50	OC 1135	1	1.0	1.0	skill 9-10

OPERATION PROFILE

NAME Parker ALC OC DATE 5/19/89 RCC MATPCA SHEET 3 OF 3

PCN/NSN/PN 97133A WCD CAEA08 WCD DATE 85033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
285	MAT PCA	ASSY	1.0	[redacted]											includes safety wiring
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.17	BEN4	1	1.0	.17	Skill 5-10
305		PW	1.0	TRANSIT											
				SETUP											
				PROCESS	–	–		1	1.0	.08	–	–	–	–	Skill 5-10
4999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	9.6									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT ______ DATE 5/18/89

ITEM CODE
PCN ☒ 97133A
NSN. ☐
P/N ☐

WCD CAEB08 WCD DATE 89033

CHART BEGINS 010 —

CHART ENDS ______ PREPARED BY [illegible]

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC			○▷D□▽	
015	015	○▷D□▽	INFO			○▷D□▽	
020	020	○▷D□▽	DIS			○▷D□▽	
030	030	○▷D□▽	CLEAN			○▷D□▽	
040	040	○▷D□▽	INSP.			○▷D□▽	
070	070	○▷D□▽	TEST			○▷D□▽	
090	090	○▷D□▽	MACH			○▷D□▽	
155	-	○▷D□▽	ASSY.			○▷D□▽	
205	-	○▷D□▽	TEST			○▷D□▽	
255	-	○▷D□▽	TEST			○▷D□▽	
285	-	○▷D□▽	ASSY			○▷D□▽	
305	-	○▷D□▽	PW.			○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽ ○▷D□▽				○▷D□▽ ○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

LSC-20147

OPERATION ?ROFILE

NAME Ricker ALC OC DATE 5/8/89 RCC MATRCA SHEET — OF —

PCN / NSN / P/N 9800IA WCD CAECO7A ✓ WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT											
00	MAT RCA	IN	1.0	SETUP											
				PROCESS	1.0	28.0									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

NOTE: This sheet FOR IN-OUT DATES

OPERATION ?OFILE

NAME Packer ALC OC DATE 5/6/8[illegible] RCC [illegible] SHEET 1 OF 10

PCN/NSN/P/N 98001A WCD CAEC07A WCD DATE [illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
010	MA PCA	REC	1.0	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	-	BY 10	1	1.0	.03	BEN2	1	1.0	.03	[illegible] 9-10
[illegible]		[illegible]	1.0	~~TRANSIT~~											
				~~SETUP~~											
				~~PROCESS~~											
018		TEST	1.0	~~TRANSIT~~											[illegible]
				SETUP	–	-		1	1.0	.03	–	-	-	-	[illegible] overhaul
				PROCESS	–	–		1	1.0	.03	OC4929	1	1.0	[illegible]	[illegible]
0[illegible]0	MAT PCM	MACH	.50	~~TRANSIT~~											MAT PCM [illegible] this opn. [illegible]
				~~SETUP~~											
				PROCESS	[illegible]	24.0	–	–	–	–	–	–	–	–	[illegible]
0[illegible]	MAT PCA	[illegible]	.50	~~TRANSIT~~											
				~~SETUP~~											
				PROCESS	–	–	BY10	1	1.0	.15	BEN2	1	1.0	.15	

OPERATION ROFILE

NAME Parker ALC OC DATE 5/18/89 RCC MAT PCA SHEET _ OF 10

PCN / NSN / P/N 98001A WCD CAECO7A WCD DATE 8 08 8

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	CLN	.50	~~TRANSIT~~											
				SETUP											
				PROCESS	-	-	BY10	1	1.0	.08	BEN2	1	1.0	.08	Skill 9-10
050		INSP	.50	TRANSIT											
				SETUP											
				PROCESS	-	-		1	1.0	.03	BEN2	1	1.0	.03	Skill 9-10
051		INSP	.50	TRANSIT											
				SETUP											
				PROCESS	-	-		1	1.0	.03	BEN2	1	1.0	.03	Skill 9-10
053		ASSY	.50	TRANSIT											
				SETUP											
				PROCESS	-	-		1	1.0	.07	BEN2	1	1.0	.07	Skill 9-10
055	MAT PIW	WELD	.50	TRANSIT											Housing to welding for add. of extension strips. Note: If housing must be extended must remove capacitor. (Problem with Fumes).
				SETUP											
				PROCESS	1.0	24.0	-	-	-	-	-			-	

LSC-20092C

OPERATION ?OFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 5 OF 10

PCN NSN P/N 98001A WCD CAE C07A ✓ WCD DATE C904B

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
060	MAT PCA	TEST	.50	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.02	BEN2	1	1.0	.02	SK ... 910
065	MAT PCM	MACH	.50	[redacted]											This opn required only 5% of the time. Dependent on results of opns 80 & 90
				[redacted]											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	
070	MAT PIW	WELD	.03	[redacted]											This opn required only 5% of the time. Dependent on results of opns 80 & 90
				[redacted]											
				PROCESS	1.0	24.0	—	—	—	—	—	—	—	—	
080	MAT PCA	TEST	.50	[redacted]											capacitor analyzer OC # 4060
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.08	OC # 4060	1	1.0	.08	SK 11 910
090		TEST	.50	~~TRANSIT~~											Req 400 V megger. Not available. Must use test stand.
				SETUP	—	—		1	1.0	.08	—	—	—	—	
				PROCESS	—	—		1	1.0	.08	OC # 5507	1	1.0	.16	SK ... 910

OPERATION PROFILE

NAME Parker ALC OC DATE 5/18/89 RCC MAT PCA SHEET 4 OF 10

PCN / NSN / P/N 98001A WCD CAECO7A WCD DATE 8'0485

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
100	MAT PCA	TEST	.50	TRANSPORT											use ohm meter
				SETUP											
				PROCESS	–	–	BY10	1	1.0	.02	BEN2	1	1.0	.02	skill 9-10
110		TEST	.50	TRANSPORT											
				SETUP											
				PROCESS	–	–		1	1.0	.02	BEN2	1	1.0	.02	skill 9-10
120		TEST	.50	TRANSPORT											
				SETUP	–	–		1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	.08	OC # 4060	1	1.0	.16	skill 9-10
[illegible]		TEST	.15	TRANSPORT											
				SETUP											
				PROCESS	–	–		1	1.0	.08	BEN	1	1.0	.08	[illegible]
[illegible]		TEST	.50	TRANSPORT											
				SETUP											
				PROCESS	–	–		1	1.0	.08	BEN2	1	1.0	.08	sk. [illegible]

OPERATION ?OFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 5 OF 10

PCN
NSN
P/N 98001A WCD CAECO7A WCD DATE 8 [illegible]

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
150	MAT PCA	TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.08	BENZ	1	1.0	.08	[illegible]
		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.08	BENZ	1	1.0	.08	SKILL 9-10
170		DIS	.50	[redacted]											
				[redacted]											[illegible]
				PROCESS		4.0		1	1.0	.80	[illegible]	1	1.0	11.5	[illegible] 9-10
175		TEST	.50	[redacted]											SKILL 9-10
				SETUP	–	–		1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	.08	OC 4060	1	1.0	.16	OC 4060
180		TEST	.50	[redacted]											TEST stand [illegible] 4060
				SETUP	–	–		1	1.0	.08	–	–	–	–	
				PROCESS	–	–		1	1.0	.12	OC 4060	1	1.0	.20	SKILL 9-10

OPERATION 3OFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 6 OF 10

PCN
NSN 98001A WCD CAEC07A WCD DATE 89 ~~06~~ 5
P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
190	MAT PCA	TEST	.50	[redacted]											[illegible] 3506
				SETUP	–	–	BY10	1	1.0	.03	–	–	–	–	
				PROCESS		–		1	1.0	.02	OC 3506	1	[illegible]	.05	SKILL 9-10
195		TEST	.5	[redacted]											
				SETUP				1	1.0	.02	–	–	–	–	
				PROCESS	–	–		1	1.0	.02	BEN15	1	1.0	.04	SKILL 9-10
200		TEST	.50	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	BEN2	1	1.0	.02	SKILL 9-10
203		TEST	.50	[redacted]											[illegible]
				SETUP	–	–		1	[illegible]	.02					
				PROCESS	–			1	1.0	.08	OC # 3953	1	1.0	.10	SKILL 9-10
205	MAT FCM	MACH	.35	[redacted]											[illegible]
				[redacted]											70% [illegible]
				PROCESS	1.0	[illegible]	–	–	–	–	–	–		–	

OPERATION PROFILE

NAME Parker ALC OC DATE 05/18/89 RCC MAT PCA SHEET 2 OF 10

PCN/NSN/P/N 98001A WCD CAEC07A WCD DATE 89088

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS		MANPOWER				EQUIPMENT				DATA SOURCE COMMENTS
					%	HRS.	SKILL CODE/ LEVEL	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	EQUIPMENT CODE	QTY.	TIME REQUIRED %	TIME REQUIRED HRS.	
207	MAT PCA	PROC	.50	[redacted]											
				[redacted]											
				PROCESS	—	—	BY10	1	1.0	.07	BEN2	1	1.0	.07	SKill 9-10
208	MAT PIW	WEID	.50	[redacted]											
				[redacted]											
				PROCESS	1.0	240	—	—	—	—	—	—	—	—	
209	MAT PCA	Test	.50	[redacted]											
				SETUP	—	—	BY10	1	1.0	.05	—	—	—	—	
				PROCESS	—	—		1	1.0	.03	4060	1	1.0	.08	SKill 9-10 Repair and replace
210		ASSY	.50	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.50	BEN2	1	1.0	.50	SKill 9-10
230		ASSY	.50	[redacted]											
				[redacted]											
				PROCESS	—	—		1	1.0	.50	BEN2	2	1.0	.50	SKill 9-10

LSC-20092C

OPERATION . . ?ROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 8 OF 10

PCN / NSN / P/N 98001A WCD CAEC07A WCD DATE 89085

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
240	MAT PCA	PROC	.50	[redacted]											Drying in oven
				SETUP	–	–	BY10	1		.05	–	–	–	–	
				PROCESS	1.0	4.75		1	1.0	.10	OC # 2758	1	1.0	4.75	Skill 9-10
250		PROC	.50	[redacted]											Fill with resin
				[redacted]											
				PROCESS	–	–		1	1.0	.18	BEN2	1	1.0	.18	Skill 9-10
260		PROC	.50	[redacted]											Baking in oven
				SETUP	–	–		1	1.0	.05	–	–	–	–	
				PROCESS	1.0	4.75		1	1.0	.10	OC # 2758	1	1.0	4.75	Skill 9-10
265		Test	.50	[redacted]											
				SETUP	–	–		1	1.0	.03	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC 3906	1	1.0	.06	Skill 9-10
270	MAT PIW	WEID	.50	[redacted]											
				[redacted]											
				PROCESS	1.0	24.0	–	–	–	–	–	–	–	–	

OPERATION . .ROFILE

NAME Parker ALC OC DATE 5/8/89 RCC MAT PCA SHEET 9 OF 10

PCN/NSN/P/N 98001A WCD CAECO2A WCD DATE 89 06

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
275	MAT PCA	PROC	.50	[redacted]											apply vacuum and heat.
				[redacted]											
				PROCESS	1.0	.5	BY10	1	1.0	.02	OC# 2758	1	1.0	.5	Sk... 9-10
300		PROC	.50	[redacted]											... pressurization and continue to heat
				[redacted]											
				PROCESS	1.0	3.0		1	1.0	.02	OC# 2758	1	1.0	3.0	Skill 9-10
305		TEST	.50	[redacted]											Test before paint. If done after and test fails, must sand-slash paint off.
				[redacted]											
				PROCESS	–	–		1	1.0	.03	BEN17	1	1.0	.03	... 9-10
310		PAINT	1.0	[redacted]											Paint plus primer. 2 hr. drying time
				[redacted]											
				PROCESS	1.0	2.0	B307	1	1.0	.3	WS9	1	1.0	.30	Skill WG-?
340		TEST	.50	[redacted]											Ohmmeter req.
				[redacted]											
				PROCESS	–	–	BY10	1	1.0	.03	BEN2	1	1.0	.03	Sk... 9-10

LSC-20092C

OPERATION PROFILE

NAME Parker ALC OC DATE 05/08/89 RCC MAT PCA SHEET 10 OF 10

PCN/NSN/PRI 98001A WCD CAEC07A WCD DATE 89098

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
350	MAT PCA	TEST	.50	[redacted]											
				SETUP	–	–	BY10	1	1.0	.03	–	–	–	–	
				PROCESS	–	–		1	1.0	.03	OC # 3906	1	1.0	.06	SKill 5-10
360		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.17	–	–	–	–	SKill 9-10
370		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–		–	SKill 9-10
380		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	SKill 9-10
385		PW	1.0	[redacted]											
				[redacted]											
				PROCESS	–	–		1	1.0	.02	–	–	–	–	SKill 5-10
9944		out	1.0	[illegible]	1.0	20.9									

LSC-20092C

FLOW PROCESS CHART

SUBJECT ________ DATE 05/08/89

ITEM CODE
PCN ☒ 98001A
NSN ☐
P/N ☐

WCD CAEC07A WCD DATE 8 ~~AUG~~ 8

CHART BEGINS 010

CHART ENDS 385 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	○▷D□▽	REC	209	–	○▷D□▽	TEST
015	015	○▷D□▽	INFO	210	210	○▷D□▽	ASSY
018	–	○▷D□▽	TEST	230	230	○▷D□▽	ASSY
020	020	○▷D□▽	MACH	240	240	○▷D□▽	PROC
030	030	○▷D□▽	DIS	250	250	○▷D□▽	PROC
040	040	○▷D□▽	CIN	260	260	○▷D□▽	PROC
050	050	○▷D□▽	INSP	265	–	○▷D□▽	TEST
051	051	○▷D□▽	INSP	270	270	○▷D□▽	WELD
053	–	○▷D□▽	ASSY	275	–	○▷D□▽	PROC
055	055	○▷D□▽	WELD	300	300	○▷D□▽	PROC
060	060	○▷D□▽	TEST	305	–	○▷D□▽	TEST
065	–	○▷D□▽	MACH	310	310	○▷D□▽	Paint
070	070	○▷D□▽	WELD	340	340	○▷D□▽	TEST
080	080	○▷D□▽	TEST	350	350	○▷D□▽	TEST
090	090	○▷D□▽	TEST	360	360	○▷D□▽	PW
100	100	○▷D□▽	TEST	370	370	○▷D□▽	PW
110	110	○▷D□▽	TEST	380	380	○▷D□▽	PW
120	120	○▷D□▽	TEST	385	385	○▷D□▽	PW
130	130	○▷D□▽	TEST			○▷D□▽	
140	140	○▷D□▽	TEST			○▷D□▽	
150	150	○▷D□▽	TEST			○▷D□▽	
160	160	○▷D□▽	TEST			○▷D□▽	
170	170	○▷D□▽	DIS			○▷D□▽	
175	–	○▷D□▽	TEST			○▷D□▽	
180	180	○▷D□▽	TEST			○▷D□▽	
190	190	○▷D□▽	TEST			○▷D□▽	
195	195	○▷D□▽	TEST			○▷D□▽	
200	200	○▷D□▽	TEST			○▷D□▽	
203	–	○▷D□▽	TEST			○▷D□▽	
205	–	○▷D□▽	MACH			○▷D□▽	
207	–	○▷D□▽	PROC			○▷D□▽	
208	–	○▷D□▽	WELD			○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

OPERATIC.. PROFILE

NAME J. CARTER ALC OC DATE 4-27-82 RCC MAT PCA SHEET 1 OF 6

PCN / NSN / P/N 98093A WCD CAEC 11 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
00	MAT PCA	IN	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	30.9									
010	MAT PCA	REC	1.000	TRANSIT			BY-10	—	—	—		—	—	—	
				SETUP				—	—	—		—	—	—	
				PROCESS	—	—		1	—	.10	7 BENCH	1	1.0	.10	BENCH
015		PW	1.000	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	—	.10	7 BENCH	1	1.0	.10	BENCH
020		DIS	1.000	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	—	2.0	7 BENCH	1	1.0	2.0	BENCH
030		CLN	1.000	TRANSIT	—	—		1	—	—	—	—	—	—	
				SETUP	—	—			—	—	—	—	—	—	CLEANING TANK - NO NUMBER
				PROCESS	—	—	BY-10	1	—	.1	BENCH	1	1.0	.10	

OPERATION PROFILE

NAME J. CARTER ALC OC DATE 11-27-89 RCC MAT PCA SHEET 2 OF 6

FCN/NSN/PIN 98093A WCD CAEC 11 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
040	MAT PCA	INSP.	1.000	TRANSIT	—	—	BY-10	—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.10	?	1	1.0	.10	
060		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.20	OC 4929	1	1.0	.20	
070		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 4929	1	1.0	.10	
070		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.10	OC 4929	1	1.0	.10	
080		TEST	1.00	TRANSIT	—	—		—	—	—	—	—	—	—	
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—	BY-10	1	1.0	.10	OC 4929	1	1.0	.10	

OPERATION PROFILE

NAME JACK CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 3 OF 6

PCN/NSN/P/N 98093A WCD CAEC11 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
				TRANSIT	—	—	—	—	—	—	—	—	—	—	
	MAT PCA			SETUP	—	—	—	—		—	—	—	—	—	
090		TEST	1.00	PROCESS	—	—	BY-10	1	1.0	.20	OC 4929	1	1.0	.20	
				TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—						—	—	—	
100		TEST	1.00	PROCESS	—	—		1	1.0	.10		—	—	—	
				TRANSIT	—	—									
				SETUP	—	—						—			
110		TEST	1.00	PROCESS	—	—		1	1.0	.10		—	—	—	
				TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
120		TEST	1.00	PROCESS	—	—		1,0	1.0	.10	OC 4929		—	—	
				TRANSIT	—	—		—	—	—	—	—	—	—	
			1.00	SETUP	—	—		—	—	—	—	—	—	—	
380		REP		PROCESS	—	—	BY10	1	1.0	.42	BENCH ?	1	1.0	.42	

OPERATIC' ROFILE

NAME J. CARTER ALC OC DATE 4/24/89 RCC MAT PCA SHEET 4 OF 6

PCN/NSN/PN 98093A WCD CAEC II WCD DATE 8904 5

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
390	MAT PCA	ASS'Y	1.0	TRANSIT	—	—	—	—	—	—	—	—	—	—	COMBINED WITH OP 440 PER ALT FAB. METHOD.
				SETUP	—	—	—	—	—	—	—	—	—	—	
				PROCESS	—	—	BY10	1	1.0	3.0	BENCH	—	—	—	
460		TEST	1.0	TRANSIT	—	—		—	—	—	—	—	—	—	TEST BENCH
				SETUP	—	—		—	—	—	—	—	—	—	
				PROCESS	—	—		1	1.0	.15	# 0C3953	1	1.0	.15	
520		BAKE	1.0	TRANSIT	—	—			—	—		—	—	—	EPOXY FILL & OVEN BAKE
				SETUP	—	—			—	—		—	—	—	
				PROCESS	1.0	3.0		1	1.0	.1	# 0C0363		1.0	.75	
525		ASS'Y.	1.0	TRANSIT	—	—									NOTE: CASE IS SOLDER-SEALED AT THIS OPER.
				SETUP	—	—									
				PROCESS				1	1.0	.30	SOLDER 30 BENCH	1	1.0	.30	
530		TEST	1.0	TRANSIT	—	—		1	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
				PROCESS	—	—	BY10	1	1.0	.10	# 0C3952	1	1.0	.10	

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OPERATION PROFILE

NAME Carter ALC OC DATE 4/24/89 RCC MAT PCA SHEET 5 OF 6

NSN 98093A WCD CAEC II WCD DATE 89045

P/N

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MAT PCA			TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
540		TEST	1.00	PROCESS	1.0	.5	BY10	1	1.0	.10	OC-3953	1	1.0	.5	
				TRANSIT	1.0	.20			—	—			—	—	PAINT BOOTH RELOCATE FOR LOGISTICS
				SETUP	—	—		—	1.0	.2			—	—	
560		PROC	1.00	PROCESS	1.0	4.0		1	1.0	.3	W53	1	1.0	.75	NO NUMBER PAINT BOOTH
				TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
570		TEST	1.00	PROCESS	—	—		1	1.0	.15	OC 4929	1	1.0	.15	ELEC TEST BENCH
				TRANSIT	—	—		—	—	—		—	—	—	
				SETUP	—	—		—	—	—		—	—	—	
650		PROC	1.00	PROCESS	—	—		1	1.0	.05	? BENCH	1	1.0	.05	INSTALL SAFETY WIRE
				TRANSIT	—	—						—	—	—	
				SETUP	—	—						—	—	—	
670	MAT PCA	PW	1.00	PROCESS	—	—	BY10	1	1.0	.1	? BENCH	1	1.0	.10	

LSC-2002C

OPERATION PROFILE

NAME J. CARTER ALC OC DATE 4-27-89 RCC MAT PCA SHEET 6 OF 6

FCN
NSN 98093A WCD CAECII ✓ WCD DATE 89045
PN

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
580	MAT PCA	PH	1.0	TRANSIT	—	—	BY	—	—	—	—	—	—	—	
				SETUP	—	—	10	—	—	—	—	—	—	—	
				PROCESS	—	—	—	1.0	1.0	.10	BENCH	1	1.0	.10	
9999		OUT	1.0	TRANSIT											
				SETUP											
				PROCESS	1.0	20.6									
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

FLOW PROCESS CHART

SUBJECT 78093A DATE 5-6-89

ITEM CODE
PCN ☐
NSN. ☐
P/N ☐

WCD CAEC11 WCD DATE 89045

CHART BEGINS OP 010

CHART ENDS OP 680 PREPARED BY

OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION	OP. PROFILE OP. NO.	WCD OP. NO.	SYMBOLS	DESCRIPTION
010	010	●▷D□▽	REC	530	570	●▷D□▽	TEST
015	015	●▷D□▽	PW	540	580	●▷D□▽	
020	020	●▷D□▽	DISASSEMB	560	590	●▷D□▽	PAINT
	025	○▷D□▽	REPAIR*		595	●▷D□▽	
030	030	●▷D□▽	CLEAN	570	610	●▷D□▽	TEST
	040	●▷D□▽	INSP	670	670	●▷D□▽	PW
060	060	○▷D□▽	TEST	650	680	●▷D□▽	SAF WIRE
	100	○▷D□▽	TEST	660	690	●▷D□▽	PW
070	160	○▷D□▽	TEST	-	700	●▷D□▽	
080	210	○▷D□▽	TEST	680	710	●▷D□▽	PW
	220	○▷D□▽	TEST			○▷D□▽	
	270	○▷D□▽	TEST			○▷D□▽	
090	290	●▷D□▽	TEST			○▷D□▽	
	300	○▷D□▽	TEST			○▷D□▽	
	310	○▷D□▽ ○▷D□▽	TEST			○▷D□▽ ○▷D□▽	
100	320	●▷D□▽	TEST			○▷D□▽	
	330	○▷D□▽				○▷D□▽	
	350	○▷D□▽				○▷D□▽	
	360	○▷D□▽				○▷D□▽	
120	380	●▷D□▽	TEST			○▷D□▽	
380	400	●▷D□▽	REPAIR			○▷D□▽	
	415	○▷D□▽				○▷D□▽	
	450	○▷D□▽				○▷D□▽	
390	480	●▷D□▽	REASS			○▷D□▽	
	490	○▷D□▽				○▷D□▽	
460	500	●▷D□▽	TEST			○▷D□▽	
520	540	●▷D□▽	Post BAKE			○▷D□▽	
	550	○▷D□▽				○▷D□▽	
525	560	●▷D□▽	SOLDER CASE			○▷D□▽	
	565	○▷D□▽				○▷D□▽	
		○▷D□▽				○▷D□▽	

○ OPERATION ▽ STORAGE □ INSPECTION
▷ TRANSPORTATION D DELAY

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5.1 PROFILE DATA FILES

The profile data files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

5.2 MODEL INPUT FILES

The model input files for RCC MATPCA were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

6.0 VALIDATION OF INPUT DATA

All profile data was validated in accordance with paragraph 7.2 and 7.3 of the Simulation Model Definition Document (SMDD). The profile data files included in this document were validated and accurately represent MATPCA.

7.0 COMPUTER SIMULATION ANALYSIS OF RCC

The computer simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

8.0 VALIDATION OF SIMULATION ANALYSIS

The validation of simulation analysis for RCC MATPCA was previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

9.0 BRAINSTORMING

The minutes for RCC MATPCA brainstorming were previously submitted under memo number NKE-E016-7643, dated August 28, 1989.

10.0 EXPERIMENTATION

Experimentation is the process by which the factors and levels developed in brainstorming are tested for interaction and effect. The factors and levels identified are fitted into a Taguchi orthogonal array, which then defines the experimental design. Changes in quality characteristics, such as throughput and/or simulated process flow times, are then analyzed as experimental results. Taguchi methodology is used in performing this analysis.

It is important to understand the process by which experimentation is developed if useful information is to be obtained. For this reason, the following discussion will attempt to define certain terms, approaches, and desired results in regard to the experimentation process.

It is often the case that technical information needed for making a decision regarding a process or product is unknown. Since this information is in most cases needed as quickly and inexpensively as possible, the Taguchi method of using fractional factorials in the form of orthogonal arrays is considered a method of choice.

Two terms require definition due to their fundamental importance in developing and interpreting the orthogonal array. A <u>factor</u> is a parameter purposefully altered so that resulting changes in the output variable may be observed. <u>Levels</u> are the different settings for each factor in a designed experiment.

The advantages of using orthogonal arrays are: ~~that~~ The main effects of factors under test are balanced and separable, the number of experiments required is greatly reduced, and the ease with which test planning and data analysis may be performed. This allows the arrays to be applied to a broad spectrum of problem identification and analysis.

Test matrices developed by Dr. Taguchi, et al, are applied to the orthogonal array for which it is applicable. Mathematical analysis of the quality characteristic chosen is then accomplished using the test matrices to find the best combination of factors and levels. The convention for identification of test matrices is as follows:

$$L_n(J^k)$$

capital J

Where N = *number of experimental runs.*
J = number of levels.

K = maximum number of factors that may be included in test.

Two factors are said to interact (in their effect on the output variable) if the effect of one factor is different at the different levels of another factor. If two factors physically interact, that effect can be identified in the test results.

Control

A note on noise: control factors are those factors easily adjusted during product design and process design. Noise factors are ~~those~~ factors which are difficult or impossible to adjust during production or customer use. Selection of those factors easiest to adjust is the best procedure when test planning begins. Because the UDOS 2.0 model produces noise-free output (100% reproducible), only control factors are included in model experimental designs.

It is important to remember that for the effective use of the UDOS 2.0 simulation model for experimental simulation analysis, the correct factors and levels must be identified and developed during initial test planning. The model allows a comparative analysis of the <u>selected</u> factors and levels, with identification of the best combination of these. It must be remembered that this may not be the optimal solution to a process or product problem, the factors and levels of which may not have been defined.

Numerous works have been produced regarding the use of Taguchi analysis in problem identification and solving in industrial settings. The reader is encouraged to examine this material, including the fundamental work of Dr. Taguchi, for specific applications and techniques.

10.1 MATPCA EXPERIMENTATION RESULTS

A statistical analysis was performed on throughput and flow time (actual vs. simulated) for the validated model run. The results of this analysis are shown in Tables 10-1 and 10-2. These results form a baseline to which the quality characteristics from the experimental model runs are compared.

The orthogonal array developed during brainstorming is shown in table 10-3. It lists the factors and levels which will form the experimental design. The use of this array reduces the number of experimental runs from 81 to nine. The experimental runs are performed on the UDOS 2.0 model using the existing (AS-IS) conditions for FY88. Note that due to the fact that throughput was 100% for all experimental runs, it is now necessary to use average simulated flow time as the quality characteristic for comparative analysis. Table 10-4 gives the result of this analysis, beginning with the average flow times of each experimental run and showing the interaction among factors and levels. The Taguchi test matrix is shown to the right of these listings. The optimal configuration is given as:

FACTOR:	A	B	C	D
LEVEL:	1	3	1	1

This configuration is interpreted as the following: (1) Add one OC 3906 Jet Ignition Tester on first shift, (2) Add two welders on first and second shifts, (3) Add one OC 4286 Temperature Amplifier Test Stand on first shift, and (4) Add one BY09 skill code position to first shift. Note that the average savings in flow time is a (simulated) 243.64 vs.

302.16 hours for the AS-IS condition. This savings in flow time would need to be compared against the cost of implementing these changes. The justification of expenditures for these changes might be more applicable if applied to surge conditions, when this reduction in flow time might prove more valuable.

The detailed results of these runs by PCN may be found in appendix A. The computer generated analysis sheets contained in appendix A, which is formed from a LOTUS 123 spreadsheet program, contain an extensive Taguchi analysis using the quality characteristics of Throughput (simulated vs. actual) and Simulated Flow Time.

10.2 SURGE ANALYSIS

Surge production capability for this RCC was performed by running a model Usage Report using the FY88 data with the surge conditions for various weapons systems as reported by ALC Headquarters. The usage report was adjusted to show the surge conditions for manpower and equipment of a seven day work week and two twelve hour shifts. The analysis of this data shows that MATPCA is a robust production area, well able to meet projected surge conditions with the present level of manpower and equipment. It should be mentioned that the existing level of experience and expertise may be directly affecting the throughput and flow hours shown, and any change to personnel or equipment needs could have an effect on surge capability.

MATPCA ELECTRICAL ACCESSORIES
THROUGHPUT STATISTICAL ANALYSIS
TABLE 10-1

PART CONTROL NUMBER (PCN)	SIMULATED	FY 88 ACTUALS	% VARIANCE (SIM /ACTUALS)
30056A	86	87	-1%
30241A	574	523	9%
31151A	326	327	-.31%
34044A	159	158	1%
34128A	590	586	1%
34252A	126	126	0%
34253A	755	758	-.40%
34551A	105	103	2%
35023A	258	255	1%
35111A	114	114	0%
35113A	137	136	1%
35510A	68	65	4%
37719A	493	488	1%
38643A	143	136	5%
38645A	299	268	10%
38669A	147	148	-1%
38694A	287	289	-1%
38718A	371	369	1%
49315A	1016	1000	2%
49711A	236	231	2%
50217A	14	14	0%
50078A	161	160	1%
97133A	141	141	0%
98001A	94	92	2%
98093A	504	501	1%
61234A	104	105	-1%
SHOP AVERAGE	7,308	7,180	2%

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MATPCA ELECTRICAL ACCESSORIES
FLOW HOURS STATISTICAL ANALYSIS
TABLE ~~[illegible]~~ 10-2

PART CONTROL NUMBER (PCN)	SIMULATED	G-019-C	% VARIANCE (SIM /ACTUALS)
30056A	78.81	408	-81%
30241A	269.95	264	2%
31151A	51.72	264	-80%
34044A	172.72	216	-20%
34128A	1204.78	240	80%
34252A	91.75	168	-45%
34253A	163.91	168	-2%
34551A	318.92	312	2%
35023A	298.99	360	-17%
35111A	75.22	192	-61%
35113A	131.44	192	-32%
35510A	163.08	312	-48%
37719A	125.24	192	-35%
38643A	187.46	192	-2%
38645A	1191.08	192	84%
38669A	154.79	312	-50%
38694A	108.86	216	-50%
38718A	281.85	336	-16%
49315A	1115.23	240	78%
49711A	445.84	216	52%
50217A	318.84	192	40%
50078A	115.02	192	-40%
97133A	86.84	288	-70%
98001A	338.63	360	6%
98093A	193.42	336	-42%
61234A	126.77	192	-34%
SHOP AVERAGE	302.16	252.0	17%

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MATPCA $L_9(3^4)$ TAGUCHI ORTHOGONAL ARRAY THROUGHPUT EXPERIMENTAL RESULTS - FY 90

TABLE [redacted] 10-3

EXP #	EQUIPMENT QUANTITY	BACKSHOP	EQUIPMENT QUANTITY	MANPOWER ASSIGNED	NORMAL WORKLOAD		
					AVG	BEST	WORST
1	ADD 1 OC 3006	3 WELDERS ON 1ST SHIFT	ADD 1 OC 4206 ON 1ST SHIFT	ADD 1 CODE BY ON 1ST SHIFT	100%	34128A 107%	40711A 98%
2	ADD 1 OC 3006	4 WELDERS ON 1ST SHIFT	ADD 2 OC 4206 ON 1ST SHIFT	ADD 2 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 99%
3	ADD 1 OC 3006	2 WELDERS ON 1ST SHIFT and 2nd shift	USE OC 4206 ON 2ND SHIFT	ADD 4 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 91%
4	ADD 2 OC 3006	3 WELDERS ON 1ST SHIFT	ADD 2 OC 4206 ON 1ST SHIFT	ADD 4 CODE BY ON 1ST SHIFT	99%	38643A 100%	40711A 99%
5	ADD 2 OC 3006	4 WELDERS ON 1ST SHIFT	USE OC 4206 ON 2ND SHIFT	ADD 1 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 99%
6	ADD 2 OC 3006	2 WELDERS ON 1ST SHIFT and 2nd shift	ADD 1 OC 4206 ON 1ST SHIFT	ADD 2 CODE BY ON 1ST SHIFT	100%	40816A 107%	40711A 99%
7	1 OC 3006 WITH 1/2 TIME	3 WELDERS ON 1ST SHIFT	USE OC 4206 ON 2ND SHIFT	ADD 2 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 98%
8	1 OC 3006 WITH 1/2 TIME	4 WELDERS ON 1ST SHIFT	ADD 1 OC 4206 ON 1ST SHIFT	ADD 4 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 100%
9	1 OC 3006 WITH 1/2 TIME	2 WELDERS ON 1ST SHIFT and 2nd shift	ADD 2 OC 4206 ON 1ST SHIFT	ADD 1 CODE BY ON 1ST SHIFT	100%	40816A 100%	40711A 98%

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ANALYSIS OF EXPERIMENTAL FLOW TIME AVERAGES USING TAGUCHI METHOD (L_9)

TABLE [redacted] 10-4

EXPERIMENTAL FLOW TIME AVERAGES -

EXP. 1	251.22
EXP. 2	239.08
EXP. 3	238.65
EXP. 4	275.43
EXP. 5	237.96
EXP. 6	232.85
EXP. 7	276.63
EXP. 8	247.76
EXP. 9	251.12

$L_9\ (3^4)$

NO	1	2	3	4
1	1	1	1	1
2	1	2	2	2
3	1	3	3	3
1	2	1	2	3
2	2	2	3	1
3	2	3	1	2
1	3	1	3	2
2	3	2	1	3
3	3	3	2	1

FACTOR	LEVEL	
1	1	242.98
	2	284.75
	3	258.50
2	1	267.76
	2	241.60
	3	240.87
3	1	243.94
	2	255.21
	3	251.08
4	1	246.77
	2	249.52
	3	253.96

LSC-20493

APPENDIX A

TAGUCHI ANALYSIS BY PCN

FOR EXPERIMENTAL RUNS

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : NATPCA PCN: 61234A PCA61234

QUARTERS =

INDUCTIONS =

	FACTOR A	FACTOR B	FACTOR C	FACTOR D	FLOW TIME	THRU PUT		FLOW TIME		THRU PUT		THRUPUT	
RUN NO.	LEVEL	LEVEL	LEVEL	LEVEL	RESULT	RESULT	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT	INDUCTIONS	SAMPLES
1	1	1	1	1	110.95	95.83333	A 1	119.2	1.36	92.8	0.05	72	69
2	1	2	2	2	125.98	91.22807	A 2	117.3	2.96	94.2	1.55	57	52
3	1	3	3	3	112.71	91.22807	A 3	126.1	-4.32	91.2	-1.60	57	52
4	2	1	2	3	119.72	89.47368	B 1	121.5	-0.55	92.2	-0.58	57	51
5	2	2	3	1	121.15	92.98245	B 2	122.9	-1.68	91.2	-1.60	57	53
6	2	3	1	2	110.95	100	B 3	118.2	2.23	94.7	2.18	55	55
7	3	1	3	2	125.88	91.22807	C 1	117.1	3.07	95.1	2.58	57	52
8	3	2	1	3	121.52	89.47368	C 2	125.5	-3.85	91.2	-1.60	57	51
9	3	3	2	1	130.8	92.98245	C 3	119.9	0.78	91.8	-0.97	57	53
							D 1	123.6	-2.30	93.9	1.31	0	0
							D 2	120.9	-0.07	94.2	1.55	0	0
			TOTAL		1088	834	D 3	118.0	2.37	90.1	-2.86	0	0
			AVERAGE		120.9	92.7		120.9	-0.00	92.7	-0.00		
			MAXIMUM		130.8	100		126.1	3.07	95.1	2.58		
			MINIMUM		110.95	89.47368		117.1	-4.32	90.1	-2.86		

TAGUCHI EXPERIMENT ANALYSIS　　　L9 ARRAY　　　05-Sep-89

ALC : OC　　RCC : MATPCA　　PCN: 98093A　　PCA98093

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	171.43	100.5952	A 1	176.5	2.70	99.1	0.31	168	169
2	1	2	2	2	179.79	98.38187	A 2	178.3	1.71	99.0	0.23	309	304
3	1	3	3	3	178.3	98.38187	A 3	189.4	-4.41	98.3	-0.54	309	304
4	2	1	2	3	182.93	98.38187	B 1	179.2	1.23	99.1	0.31	309	304
5	2	2	3	1	177.5	98.38187	B 2	183.3	-1.04	98.3	-0.54	309	304
6	2	3	1	2	174.45	100.3460	B 3	181.7	-0.19	99.0	0.23	289	290
7	3	1	3	2	183.17	98.38187	C 1	179.5	1.06	99.7	0.87	309	304
8	3	2	1	3	192.56	98.05825	C 2	185.1	-2.02	98.4	-0.43	309	303
9	3	3	2	1	192.46	98.38187	C 3	179.7	0.96	98.4	-0.43	309	304
							D 1	180.5	0.52	99.1	0.31	0	0
							D 2	179.1	1.25	99.0	0.23	0	0
			TOTAL		1633	889	D 3	184.6	-1.76	98.3	-0.54	0	0
			AVERAGE		181.4	98.8		181.4	-0.00	98.8	0.00		
			MAXIMUM		192.56	100.5952		189.4	2.70	99.7	0.87		
			MINIMUM		171.43	98.05825		176.5	-4.41	98.3	-0.54		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : 0C RCC : MATPCA PCN: 98001A PCA98001

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	404.85	101.7241	A 1	339.2	8.02	100.6	0.63	58	59
2	1	2	2	2	299.05	102.1276	A 2	356.2	3.44	100.0	0.02	47	48
3	1	3	3	3	313.79	97.87234	A 3	411.1	-11.46	99.3	-0.65	47	46
4	2	1	2	3	403.56	100	B 1	460.2	-24.78	101.3	1.34	47	47
5	2	2	3	1	290.76	97.87234	B 2	318.2	13.73	100.0	0.06	47	46
6	2	3	1	2	294.13	102	B 3	328.1	11.05	98.5	-1.40	50	51
7	3	1	3	2	492.28	102.1276	C 1	354.6	3.86	101.2	1.30	47	48
8	3	2	1	3	364.75	100	C 2	386.3	-4.74	99.3	-0.65	47	47
9	3	3	2	1	376.26	95.74468	C 3	365.6	0.87	99.3	-0.65	47	45
							D 1	357.3	3.13	98.4	-1.49	0	0
							D 2	361.8	1.90	102.1	2.15	0	0
			TOTAL		3319	899	D 3	387.4	-5.03	99.3	-0.65	0	0
			AVERAGE		368.8	99.9		368.8	0.00	99.9	0.00		
			MAXIMUM		492.28	102.1276		460.2	13.73	102.1	2.15		
			MINIMUM		290.76	95.74468		318.2	-24.78	98.4	-1.49		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : QC RCC : MATPCA PCN: 97133A PCA97133

QUARTERS =
INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	INHUPUT INDUCTIONS	INHUPUT SAMPLES
1	1	1	1	1	90.2	102	A 1	86.3	-0.91	99.9	0.70	50	51
2	1	2	2	2	84.07	98.83720	A 2	85.4	0.18	98.9	-0.33	86	85
3	1	3	3	3	84.69	98.83720	A 3	84.9	0.73	98.8	-0.36	86	85
4	2	1	2	3	83.65	98.83720	B 1	86.6	-1.19	99.9	0.70	86	85
5	2	2	3	1	87.96	98.83720	B 2	85.7	-0.17	98.8	-0.36	86	85
6	2	3	1	2	84.54	98.92473	B 3	84.4	1.36	98.9	-0.33	93	92
7	3	1	3	2	85.82	98.83720	C 1	86.6	-1.22	99.9	0.73	86	85
8	3	2	1	3	85.01	98.83720	C 2	83.9	1.95	98.8	-0.36	86	85
9	3	3	2	1	83.9	98.83720	C 3	86.2	-0.72	98.8	-0.36	86	85
							D 1	87.4	-2.12	99.9	0.70	0	0
							D 2	84.8	0.85	98.9	-0.33	0	0
			TOTAL		770	893	D 3	84.5	1.27	98.8	-0.36	0	0
			AVERAGE		85.5	99.2		85.5	-0.00	99.2	0.00		
			MAXIMUM		90.2	102		87.4	1.95	99.9	0.73		
			MINIMUM		83.65	98.83720		83.9	-2.12	98.8	-0.36		

TAGUCHI EXPERIMENT ANALYSIS   L9 ARRAY   05-Sep-89
ALC : OC   RCC : MATPCA   PCN: 5007B   PCA5007B

QUARTERS =
INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	104.4	97.72727	A 1	103.2	1.13	97.9	0.58	88	86
2	1	2	2	2	100.24	98.63013	A 2	101.0	3.23	97.3	-0.05	73	72
3	1	3	3	3	97.03	97.26027	A 3	109.0	-4.36	96.8	-0.52	73	71
4	2	1	2	3	104.06	94.52054	B 1	103.3	1.02	96.5	-0.83	73	69
5	2	2	3	1	101.84	97.26027	B 2	106.7	-2.16	96.8	-0.52	73	71
6	2	3	1	2	97.19	100	B 3	103.2	1.14	98.6	1.35	75	75
7	3	1	3	2	101.55	97.26027	C 1	103.8	0.55	97.4	0.11	73	71
8	3	2	1	3	109.89	94.52054	C 2	109.2	-4.63	97.3	-0.05	73	69
9	3	3	2	1	115.42	98.63013	C 3	100.1	4.08	97.3	-0.05	73	72
							D 1	107.2	-2.70	97.9	0.58	0	0
							D 2	102.3	1.99	98.6	1.35	0	0
			TOTAL		940	876	D 3	103.7	0.71	95.4	-1.93	0	0
			AVERAGE		104.4	97.3		104.4	-0.00	97.3	-0.00		
			MAXIMUM		115.42	100		109.2	4.08	98.6	1.35		
			MINIMUM		97.03	94.52054		100.1	-4.63	95.4	-1.93		

TAGUCHI EXPERIMENT ANALYSIS   L9 ARRAY   05-Sep-89

ALC : OC   RCC : HATPCA   PCN: 50217A   PCA50217

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	264.69	99.29577	A 1	289.5	-0.50	93.1	5.27	142	141
2	1	2	2	2	323.39	90	A 2	263.7	8.45	82.2	-7.03	10	9
3	1	3	3	3	280.42	90	A 3	310.9	-7.94	90.0	1.76	10	9
4	2	1	2	3	281.41	90	B 1	276.2	4.10	93.1	5.27	10	9
5	2	2	3	1	300.71	90	B 2	318.1	-10.44	90.0	1.76	10	9
6	2	3	1	2	209.02	66.66666	B 3	269.8	6.34	82.2	-7.03	3	2
7	3	1	3	2	282.59	90	C 1	268.0	6.96	85.3	-3.53	10	9
8	3	2	1	3	330.3	90	C 2	308.2	-7.01	90.0	1.76	10	9
9	3	3	2	1	319.9	90	C 3	287.9	0.05	90.0	1.76	10	9
							D 1	295.1	-2.45	93.1	5.27	0	0
							D 2	271.7	5.69	82.2	-7.03	0	0
			TOTAL		2592	796	D 3	297.4	-3.24	90.0	1.76	0	0
			AVERAGE		288.0	88.4		288.0	0.00	88.4	-0.00		
			MAXIMUM		330.3	99.29577		318.1	8.45	93.1	5.27		
			MINIMUM		209.02	66.66666		263.7	-10.44	82.2	-7.03		

TAGUCHI EXPERIMENT ANALYSIS   L9 ARRAY   05-Sep-89

ALC : OC   RCC : MATPCA   PCN: 49711A   PCA49711

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	469.93	94.01709	A 1	382.8	7.42	93.6	0.60	117	110
2	1	2	2	2	332.59	96.07843	A 2	397.1	3.97	93.5	0.41	153	147
3	1	3	3	3	346.01	90.84967	A 3	460.7	-11.40	92.2	-1.01	153	139
4	2	1	2	3	560.66	90.19607	B 1	530.8	-28.35	91.9	-1.28	153	138
5	2	2	3	1	313.76	92.81045	B 2	350.0	15.36	93.9	0.87	153	142
6	2	3	1	2	316.9	97.41935	B 3	359.8	12.99	93.5	0.41	155	151
7	3	1	3	2	561.71	91.50326	C 1	396.8	4.04	94.7	1.78	153	140
8	3	2	1	3	403.67	92.81045	C 2	436.6	-5.58	92.8	-0.30	155	142
9	3	3	2	1	416.6	92.15686	C 3	407.2	1.54	91.7	-1.47	153	141
							D 1	400.1	3.25	93.0	-0.11	0	0
							D 2	403.7	2.37	95.0	2.05	0	0
			TOTAL		3722	838	D 3	436.8	-5.62	91.3	-1.94	0	0
			AVERAGE		413.5	93.1		413.5	0.00	93.1	0.00		
			MAXIMUM		561.71	97.41935		530.8	15.36	95.0	2.05		
			MINIMUM		313.76	90.19607		350.0	-28.35	91.3	-1.94		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC REC : MATPCA PCN: 49315A PCA49315A

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	1237.40	95.95238	A 1	1166.3	5.96	105.1	-1.10	420	403
2	1	2	2	2	1125.3	109.5238	A 2	1276.6	-2.94	106.6	0.26	525	575
3	1	3	3	3	1136.16	109.7142	A 3	1277.6	-3.02	107.3	0.92	525	576
4	2	1	2	3	1560.13	102.0571	B 1	1457.0	-17.48	100.7	-5.30	525	540
5	2	2	3	1	1124.56	109.5238	B 2	1125.3	9.27	109.5	3.01	525	575
6	2	3	1	2	1137.2	107.4003	B 3	1138.3	0.22	100.8	2.29	527	566
7	3	1	3	2	1565.33	103.2380	C 1	1166.9	5.91	104.3	-1.91	525	542
8	3	2	1	3	1125.97	109.5238	C 2	1270.3	-3.00	107.2	0.80	525	575
9	3	3	2	1	1141.55	109.1428	C 3	1275.4	-2.04	107.5	1.10	525	573
							D 1	1167.9	5.83	104.9	-1.36	0	0
							D 2	1275.9	-2.88	106.7	0.38	0	0
			TOTAL		11162	957	D 3	1276.0	-2.95	107.4	0.98	0	0
			AVERAGE		1240.2	106.3		1240.2	0.00	106.3	-0.00		
			MAXIMUM		1560.13	109.7142		1457.0	9.27	109.5	3.01		
			MINIMUM		1124.56	95.95238		1125.3	-17.48	100.7	-5.30		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 30718A PCA30718

QUARTERS =
INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	279.34	97.70992	A 1	281.0	0.21	97.5	-0.71	151	120
2	1	2	2	2	281.83	97.34042	A 2	281.2	0.12	99.7	1.56	188	183
3	1	3	3	3	281.71	97.34042	A 3	282.5	-0.33	97.3	-0.84	188	183
4	2	1	2	3	281.54	97.34042	B 1	280.9	0.24	97.5	-0.71	188	183
5	2	2	3	1	281.49	97.34042	B 2	282.1	-0.20	97.3	-0.84	188	183
6	2	3	1	2	280.56	104.3956	B 3	281.7	-0.05	99.7	1.56	182	190
7	3	1	3	2	281.71	97.34042	C 1	281.0	0.21	99.8	1.68	188	183
8	3	2	1	3	282.96	97.34042	C 2	282.0	-0.18	97.3	-0.84	188	183
9	3	3	2	1	282.74	97.34042	C 3	281.6	-0.03	97.3	-0.84	188	183
							D 1	281.2	0.13	97.5	-0.71	0	0
							D 2	281.4	0.06	99.7	1.56	0	0
			TOTAL		2534	883	D 3	282.1	-0.19	97.3	-0.84	0	0
			AVERAGE		281.5	98.2		281.5	0.00	98.2	0.00		
			MAXIMUM		282.96	104.3956		282.5	0.24	99.8	1.68		
			MINIMUM		279.34	97.34042		280.9	-0.33	97.3	-0.84		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : HATPCA PCN: 38694A PCA38694

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	117.32	97.00737	A 1	112.4	1.03	98.4	-0.86	163	160
2	1	2	2	2	109.51	98.78787	A 2	114.5	-0.83	100.0	0.73	165	163
3	1	3	3	3	110.44	99.39393	A 3	113.8	-0.21	99.4	0.12	165	164
4	2	1	2	3	119.48	99.39393	B 1	118.8	-4.54	98.8	-0.45	165	164
5	2	2	3	1	114.69	100.6060	B 2	112.2	1.27	99.6	0.33	165	166
6	2	3	1	2	109.45	100	B 3	109.9	3.27	99.4	0.12	156	156
7	3	1	3	2	119.47	100	C 1	113.0	0.51	98.8	-0.45	165	165
8	3	2	1	3	112.28	99.39393	C 2	112.9	0.60	99.0	-0.28	165	164
9	3	3	2	1	109.75	98.78787	C 3	114.9	-1.12	100.0	0.73	165	163
							D 1	113.9	-0.28	98.8	-0.45	0	0
							D 2	112.8	0.69	99.6	0.33	0	0
			TOTAL		1022	893	D 3	114.1	-0.41	99.4	0.12	0	0
			AVERAGE		113.6	99.3		113.6	0.00	99.3	-0.00		
			MAXIMUM		119.48	100.6060		118.8	3.27	100.0	0.73		
			MINIMUM		109.45	97.00737		109.9	-4.54	98.4	-0.86		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 38669A PCA38669

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	142.64	100	A 1	142.3	0.18	100.5	0.30	50	50
2	1	2	2	2	142.32	101.3698	A 2	139.0	2.55	100.0	-0.15	73	74
3	1	3	3	3	142.05	100	A 3	146.5	-2.74	100.0	-0.15	73	73
4	2	1	2	3	139.06	100	B 1	141.1	1.05	100.0	-0.15	73	73
5	2	2	3	1	138.8	100	B 2	142.7	-0.09	100.5	0.30	73	73
6	2	3	1	2	139.01	100	B 3	144.0	-0.96	100.0	-0.15	76	76
7	3	1	3	2	141.59	100	C 1	142.9	-0.21	100.0	-0.15	73	73
8	3	2	1	3	147.06	100	C 2	144.1	-1.04	100.5	0.30	73	73
9	3	3	2	1	150.85	100	C 3	140.8	1.25	100.0	-0.15	73	73
							D 1	144.1	-1.05	100.0	-0.15	0	0
							D 2	141.0	1.14	100.5	0.30	0	0
			TOTAL		1283	901	D 3	142.7	-0.09	100.0	-0.15	0	0
			AVERAGE		142.6	100.2		142.6	-0.00	100.2	0.00		
			MAXIMUM		150.85	101.3698		146.5	2.55	100.5	0.30		
			MINIMUM		138.8	100		139.0	-2.74	100.0	-0.15		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 306454 PCA38645

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	106.04	99.04761	A 1	94.6	3.90	99.0	-0.73
2	1	2	2	2	75.96	99.33774	A 2	115.2	-17.03	100.7	0.92
3	1	3	3	3	101.75	98.67549	A 3	85.5	13.13	99.6	-0.19
4	2	1	2	3	116.03	98.67549	B 1	107.7	-9.40	99.2	-0.51
5	2	2	3	1	119.55	101.3245	B 2	91.6	6.91	100.0	0.25
6	2	3	1	2	109.95	102.0134	B 3	95.9	2.57	100.0	0.26
7	3	1	3	2	101.17	100	C 1	98.4	-0.03	100.1	0.38
8	3	2	1	3	79.35	99.33774	C 2	89.3	9.25	99.1	-0.63
9	3	3	2	1	75.97	99.33774	C 3	107.5	-9.22	100.0	0.25
							D 1	100.5	-2.13	99.9	0.15
							D 2	95.7	2.77	100.5	0.70
			TOTAL		886	898	D 3	99.0	-0.63	98.9	-0.86
			AVERAGE		98.4	99.7		98.4	0.00	99.7	-0.00
			MAXIMUM		119.55	102.0134		115.2	13.13	100.7	0.92
			MINIMUM		75.96	98.67549		85.5	-17.03	98.9	-0.86

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MAIPCA PCN: 38643A PCA38643

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	93.18	101.7543	A 1	108.8	1.03	103.5	0.60
2	1	2	2	2	107.96	104.3478	A 2	111.8	-1.73	101.5	-1.33
3	1	3	3	3	125.21	104.3478	A 3	109.2	0.69	103.6	0.73
4	2	1	2	3	102.75	104.3478	B 1	106.5	3.13	102.8	-0.11
5	2	2	3	1	115.18	104.3478	B 2	109.1	0.76	104.3	1.44
6	2	3	1	2	117.53	95.78947	B 3	114.2	-3.89	101.5	-1.33
7	3	1	3	2	123.5	102.1739	C 1	104.9	4.53	100.6	-2.17
8	3	2	1	3	104.12	104.3478	C 2	103.5	5.82	104.3	1.44
9	3	3	2	1	99.85	104.3478	C 3	121.3	-10.35	103.6	0.73
							D 1	102.7	6.54	103.5	0.60
							D 2	116.3	-5.83	100.8	-2.04
			TOTAL		989	926	D 3	110.7	-0.70	104.3	1.44
			AVERAGE		109.9	102.9		109.9	0.00	102.9	0.00
			MAXIMUM		125.21	104.3478		121.3	6.54	104.3	1.44
			MINIMUM		93.18	95.78947		102.7	-10.35	100.6	-2.17

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 37719A PCA37719

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	119.50	98.61751	A 1	120.4	-8.69	100.3	-0.61
2	1	2	2	2	120.13	101.1952	A 2	0.0	100.00	101.3	0.38
3	1	3	3	3	121.35	101.1952	A 3	121.1	-9.40	101.2	0.24
4	2	1	2	3	120.0	101.1952	B 1	120.4	-8.73	100.3	-0.61
5	2	2	3	1	120.88	101.1952	B 2	120.9	-9.15	101.2	0.24
6	2	3	1	2	121.09	101.6129	B 3	121.2	-9.42	101.3	0.38
7	3	1	3	2	120.81	101.1952	C 1	120.7	-9.05	100.5	-0.40
8	3	2	1	3	121.57	101.1952	C 2	120.7	-8.97	101.2	0.24
9	3	3	2	1	121.05	101.1952	C 3	121.0	-9.29	101.2	0.24
							D 1	120.5	-8.83	100.3	-0.61
							D 2	120.7	-8.98	101.3	0.38
			TOTAL		1087	909	D 3	121.2	-9.49	101.2	0.24
			AVERAGE		120.8	101.0		110.7	0.00	101.0	0.00
			MAXIMUM		121.57	101.6129		121.2	100.00	101.3	0.38
			MINIMUM		119.50	98.61751		0.0	-9.49	100.3	-0.61

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 35510A PCA35510A

QUARTERS =

INDUCTIONS =

	FACTOR A	FACTOR B	FACTOR C	FACTOR D	FLOW TIME	THRU PUT		FLOW TIME		THRU PUT		THRUPUT	
RUN NO.	LEVEL	LEVEL	LEVEL	LEVEL	RESULT	RESULT	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT	INDUCTIONS	SAMPLES
1	1	1	1	1	140.02	100	A 1	143.9	2.53	102.1	-5.23	44	44
2	1	2	2	2	152.66	106.25	A 2	138.6	6.12	115.9	7.57	32	34
3	1	3	3	3	139.00	100	A 3	160.4	-8.65	105.2	-2.33	32	32
4	2	1	2	3	141.04	103.125	B 1	144.9	1.88	103.1	-4.27	32	33
5	2	2	3	1	140.4	106.25	B 2	153.0	-3.60	107.3	-0.40	32	34
6	2	3	1	2	126.43	138.2352	B 3	145.1	1.72	112.7	4.66	34	47
7	3	1	3	2	153.57	106.25	C 1	141.4	4.21	115.9	7.57	32	34
8	3	2	1	3	157.07	109.375	C 2	154.5	-4.65	103.1	-4.27	32	35
9	3	3	2	1	169.05	100	C 3	147.0	0.43	104.2	-3.50	32	32
							D 1	152.8	-3.45	102.1	-5.23	0	0
							D 2	144.2	2.33	116.9	8.53	0	0
			TOTAL		1329	969	D 3	146.0	1.12	104.2	-3.30	0	0
			AVERAGE		147.7	107.7		147.7	-0.00	107.7	0.00		
			MAXIMUM		169.05	138.2352		160.4	6.12	116.9	8.53		
			MINIMUM		126.43	100		138.6	-8.65	102.1	-5.23		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 35113A PCA35113A

QUARTERS =
INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	122.65	100	A 1	126.2	2.76	95.7	0.81	62	62
2	1	2	2	2	129.34	94.20289	A 2	131.1	-1.00	95.8	0.93	69	65
3	1	3	3	3	126.72	92.75362	A 3	132.1	-1.76	93.2	-1.74	69	64
4	2	1	2	3	135.22	92.75362	B 1	129.9	-0.09	95.2	0.30	69	64
5	2	2	3	1	129.07	92.75362	B 2	130.6	-0.63	93.2	-1.74	69	64
6	2	3	1	2	129.03	101.8181	B 3	128.9	0.72	96.3	1.44	55	56
7	3	1	3	2	131.92	92.75362	C 1	128.4	1.09	98.2	3.48	69	64
8	3	2	1	3	133.5	92.75362	C 2	131.8	-1.54	93.7	-1.23	69	64
9	3	3	2	1	130.87	94.20289	C 3	129.2	0.44	92.8	-2.25	69	65
							D 1	127.5	1.76	95.7	0.81	0	0
							D 2	130.1	-0.22	96.3	1.44	0	0
			TOTAL		1168	854	D 3	131.8	-1.54	92.8	-2.25	0	0
			AVERAGE		129.8	94.9		129.8	0.00	94.9	0.00		
			MAXIMUM		135.22	101.8181		132.1	2.76	98.2	3.48		
			MINIMUM		122.65	92.75362		126.2	-1.76	92.8	-2.25		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 35111A PCA35111A

QUARTERS =

INDUCTIONS =

	FACTOR A	FACTOR B	FACTOR C	FACTOR D	FLOW TIME	THRU PUT		FLOW TIME		THRU PUT		THRUPUT	
RUN NO.	LEVEL	LEVEL	LEVEL	LEVEL	RESULT	RESULT	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT	INDUCTIONS	SAMPLES
1	1	1	1	1	73.12	94.11764	A 1	72.8	-0.24	97.0	-1.36	51	49
2	1	2	2	2	72.06	98.38709	A 2	72.7	-0.17	99.6	1.27	62	61
3	1	3	3	3	73.11	98.38709	A 3	72.3	0.41	98.4	0.09	62	61
4	2	1	2	3	72.03	98.38709	B 1	72.7	-0.09	97.0	-1.36	62	61
5	2	2	3	1	72.09	98.38709	B 2	72.1	0.71	98.4	0.09	62	61
6	2	3	1	2	74	101.0067	B 3	73.0	-0.61	99.6	1.27	53	54
7	3	1	3	2	72.81	98.38709	C 1	73.1	-0.66	98.1	-0.17	62	61
8	3	2	1	3	72.07	98.38709	C 2	72.0	0.77	98.4	0.09	62	61
9	3	3	2	1	71.98	98.38709	C 3	72.7	-0.12	98.4	0.09	62	61
							D 1	72.4	0.26	97.0	-1.36	0	0
							D 2	73.0	-0.51	99.6	1.27	0	0
			TOTAL		653	885	D 3	72.4	0.25	98.4	0.09	0	0
			AVERAGE		72.6	98.3		72.6	0.00	98.3	-0.00		
			MAXIMUM		74	101.0067		73.1	0.77	99.6	1.27		
			MINIMUM		71.98	94.11764		72.0	-0.66	97.0	-1.36		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 35023A PCA35023A

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	208.54	102.0979	A 1	198.2	3.20	101.3	0.25	143	146
2	1	2	2	2	194.07	101.2345	A 2	195.3	4.65	100.0	-1.04	162	164
3	1	3	3	3	192.07	100.6172	A 3	220.8	-7.85	101.9	0.78	162	163
4	2	1	2	3	216.47	101.8518	B 1	214.9	-4.95	101.9	0.87	162	165
5	2	2	3	1	184.72	100.6172	B 2	196.8	3.88	101.2	0.17	162	163
6	2	3	1	2	184.56	97.56097	B 3	202.6	1.07	100.0	-1.04	164	160
7	3	1	3	2	219.72	101.8518	C 1	201.6	1.56	100.5	-0.55	162	165
8	3	2	1	3	211.67	101.8518	C 2	213.9	-4.45	101.6	0.58	162	165
9	3	3	2	1	231.15	101.8518	C 3	198.8	2.90	101.0	-0.03	162	165
							D 1	208.1	-1.64	101.5	0.46	0	0
							D 2	199.5	2.60	100.2	-0.83	0	0
			TOTAL		1843	910	D 3	206.7	-0.96	101.4	0.38	0	0
			AVERAGE		204.8	101.1		204.8	-0.00	101.1	-0.00		
			MAXIMUM		231.15	102.0979		220.8	4.65	101.9	0.87		
			MINIMUM		184.56	97.56097		195.3	-7.85	100.0	-1.04		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : NATPCA PCN: 34551A PCA34551

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	INPUT INDUCTIONS	INPUT SAMPLES
1	1	1	1	1	315.57	102.1276	A 1	315.8	0.09	104.3	-0.52	47	48
2	1	2	2	2	315.98	105.4545	A 2	316.2	-0.04	104.9	-0.02	55	58
3	1	3	3	3	315.9	105.4545	A 3	316.2	-0.05	105.5	0.54	55	58
4	2	1	2	3	315.91	105.4545	B 1	315.9	0.05	104.3	-0.52	55	58
5	2	2	3	1	316.38	105.4545	B 2	316.1	-0.00	105.5	0.54	55	58
6	2	3	1	2	316.34	103.7037	B 3	316.2	-0.05	104.9	-0.02	54	56
7	3	1	3	2	316.36	105.4545	C 1	315.9	0.05	103.8	-1.08	55	58
8	3	2	1	3	315.91	105.4545	C 2	316.1	-0.01	105.5	0.54	55	58
9	3	3	2	1	316.46	105.4545	C 3	316.2	-0.04	105.5	0.54	55	58
							D 1	316.1	-0.01	104.3	-0.52	0	0
							D 2	316.2	-0.04	104.9	-0.02	0	0
			TOTAL		2845	944	D 3	315.9	0.06	105.5	0.54	0	0
			AVERAGE		316.1	104.9		316.1	-0.00	104.9	0.00		
			MAXIMUM		316.46	105.4545		316.2	0.09	105.5	0.54		
			MINIMUM		315.57	102.1276		315.8	-0.05	103.8	-1.08		

TAGUCHI EXPERIMENT ANALYSIS   L9 ARRAY   05-Sep-89

ALC : OC   RCC : MATPCA   PCN: 34253A   PCA34253

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	148.67	100.0049	A 1	147.4	0.43	99.9	0.42	452	456
2	1	2	2	2	151.32	99.34426	A 2	148.5	-0.29	99.2	-0.20	305	303
3	1	3	3	3	142.34	99.34426	A 3	148.3	-0.14	99.2	-0.21	305	303
4	2	1	2	3	153.46	98.68852	B 1	148.9	-0.58	99.5	0.09	305	301
5	2	2	3	1	150.5	99.67213	B 2	150.6	-1.72	99.5	0.01	305	304
6	2	3	1	2	141.59	99.36305	B 3	144.7	2.30	99.4	-0.09	314	312
7	3	1	3	2	144.69	99.01639	C 1	146.8	0.89	99.9	0.42	305	302
8	3	2	1	3	150.05	99.34426	C 2	151.6	-2.40	99.1	-0.32	305	303
9	3	3	2	1	150.12	99.34426	C 3	145.8	1.51	99.3	-0.10	305	303
							D 1	149.8	-1.14	100.0	0.53	0	0
							D 2	145.9	1.50	99.2	-0.20	0	0
			TOTAL		1333	895	D 3	148.6	-0.36	99.1	-0.32	0	0
			AVERAGE		148.1	99.4		148.1	-0.00	99.4	0.00		
			MAXIMUM		153.46	100.0049		151.6	2.30	100.0	0.53		
			MINIMUM		141.59	98.68852		144.7	-2.40	99.1	-0.32		

TAGUCHI EXPERIMENT ANALYSIS   L9 ARRAY   05-Sep-89

ALC : 0C   RCC : MATPCA   PCN: 342526   PCA34252

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	INPUT INDUCTIONS	INPUT SAMPLES
1	1	1	1	1	77.7	95.77464	A 1	77.3	2.55	99.9	-0.73	71	68
2	1	2	2	2	79.51	101.9230	A 2	80.6	-1.60	101.3	0.69	52	53
3	1	3	3	3	74.54	101.9230	A 3	80.0	-0.87	100.6	0.04	52	53
4	2	1	2	3	80.73	100	B 1	78.1	1.50	98.6	-2.00	52	52
5	2	2	3	1	80.26	101.9230	B 2	81.2	-2.38	101.3	0.67	52	53
6	2	3	1	2	80.81	101.9607	B 3	78.6	0.88	101.9	1.32	51	52
7	3	1	3	2	75.02	100	C 1	80.7	-1.85	99.2	-1.35	52	52
8	3	2	1	3	83.69	100	C 2	80.2	-1.17	101.3	0.67	52	52
9	3	3	2	1	80.36	101.9230	C 3	76.9	3.02	101.3	0.67	52	53
							D 1	79.4	-0.22	99.9	-0.73	0	0
							D 2	78.7	0.70	101.3	0.69	0	0
			TOTAL		713	905	D 3	79.7	-0.46	100.6	0.04	0	0
			AVERAGE		79.3	100.6		79.3	0.00	100.6	-0.00		
			MAXIMUM		83.69	101.9607		81.2	3.02	101.9	1.32		
			MINIMUM		74.54	95.77464		76.9	-2.38	98.6	-2.00		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 34120A PCA34120

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	1202.93	107.0270	A 1	1203.1	-0.00	101.7	1.97	370	396
2	1	2	2	2	1203.93	99.04153	A 2	1203.0	0.01	98.5	-1.26	313	310
3	1	3	3	3	1202.53	99.04153	A 3	1203.1	-0.00	99.0	-0.70	313	310
4	2	1	2	3	1201.83	99.04153	B 1	1202.5	0.04	101.7	1.97	313	310
5	2	2	3	1	1204.02	99.04153	B 2	1203.4	-0.03	99.0	-0.70	313	310
6	2	3	1	2	1203.07	97.36842	B 3	1203.3	-0.02	98.5	-1.26	304	296
7	3	1	3	2	1202.05	99.04153	C 1	1202.8	0.03	101.1	1.41	313	310
8	3	2	1	3	1202.29	99.04153	C 2	1203.3	-0.02	99.0	-0.70	313	310
9	3	3	2	1	1204.25	99.04153	C 3	[illegible].1	-0.00	99.0	-0.70	313	310
							D 1	1203.7	-0.05	101.7	1.97	0	0
							D 2	1203.3	-0.02	98.5	-1.26	0	0
			TOTAL		10828	898	D 3	1202.2	0.07	99.0	-0.70	0	0
			AVERAGE		1203.1	99.7		1203.1	0.00	99.7	0.00		
			MAXIMUM		1204.25	107.0270		1203.7	0.07	101.7	1.97		
			MINIMUM		1201.83	97.36842		1202.2	-0.05	98.5	-1.26		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : NATPCA PCN: 31151A PCA31151

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT	THRUPUT INDUCTIONS	THRUPUT SAMPLES
1	1	1	1	1	49.42	99.40453	A 1	48.6	-1.06	99.5	-0.18	194	193
2	1	2	2	2	48.07	99.46808	A 2	47.6	1.13	100.0	0.37	168	187
3	1	3	3	3	48.4	99.46808	A 3	48.2	-0.08	99.5	-0.19	188	187
4	2	1	2	3	47.98	99.46808	B 1	48.6	-1.00	99.5	-0.18	188	187
5	2	2	3	1	48.24	99.46808	B 2	48.1	-0.04	99.5	0.19	188	187
6	2	3	1	2	46.51	101.1363	B 3	47.6	1.04	100.0	0.37	176	178
7	3	1	3	2	48.41	99.46808	C 1	48.0	0.23	100.0	0.38	188	187
8	3	2	1	3	48.11	99.46808	C 2	48.0	0.25	99.5	-0.19	188	187
9	3	3	2	1	47.96	99.46808	C 3	48.4	-0.47	99.5	-0.19	188	187
							D 1	48.5	-0.87	99.5	-0.18	0	0
							D 2	47.7	0.95	100.0	0.37	0	0
			TOTAL		433	897	D 3	48.2	-0.09	99.5	-0.19	0	0
			AVERAGE		48.1	99.7		48.1	-0.00	99.7	0.00		
			MAXIMUM		49.42	101.1363		48.6	1.13	100.0	0.38		
			MINIMUM		46.51	99.46808		47.6	-1.06	99.5	-0.19		

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 30241A PCA30241

QUARTERS =

INDUCTIONS =

RUN NO.	FACTOR A LEVEL	FACTOR B LEVEL	FACTOR C LEVEL	FACTOR D LEVEL	FLOW TIME RESULT	THRU PUT RESULT	FACTOR	FLOW TIME EFFECT	FLOW TIME PERCENT	THRU PUT EFFECT	THRU PUT PERCENT
1	1	1	1	1	244.04	102.7777	A 1	228.9	7.28	101.9	0.82
2	1	2	2	2	217.48	101.6438	A 2	243.3	1.43	101.2	0.09
3	1	3	3	3	225	101.3698	A 3	268.4	-8.71	100.2	-0.91
4	2	1	2	3	298	100.2739	B 1	280.8	-13.76	101.0	-0.09
5	2	2	3	1	210.72	101.9178	B 2	222.3	9.97	101.5	0.35
6	2	3	1	2	221.26	101.4005	B 3	237.5	3.79	100.8	-0.27
7	3	1	3	2	300.48	100	C 1	234.6	4.98	101.7	0.56
8	3	2	1	3	230.39	100.8219	C 2	260.6	-5.58	100.5	-0.55
9	3	3	2	1	266.24	99.72602	C 3	245.4	0.59	101.1	-0.01
							D 1	240.3	2.65	101.5	0.37
							D 2	246.5	0.16	101.0	-0.09
			TOTAL		2222	910	D 3	253.8	-2.81	100.8	-0.28
			AVERAGE		246.9	101.1		246.9	-0.00	101.1	0.00
			MAXIMUM		300.48	102.7777		280.8	9.97	101.9	0.82
			MINIMUM		210.72	99.72602		222.3	-13.76	100.2	-0.91

TAGUCHI EXPERIMENT ANALYSIS L9 ARRAY 05-Sep-89

ALC : OC RCC : MATPCA PCN: 30056A PCA30056

QUARTERS =

INDUCTIONS =

	FACTOR A	FACTOR B	FACTOR C	FACTOR D	FLOW TIME	THRU PUT		FLOW TIME		THRU PUT	
RUN NO.	LEVEL	LEVEL	LEVEL	LEVEL	RESULT	RESULT	FACTOR	EFFECT	PERCENT	EFFECT	PERCENT
1	1	1	1	1	73.77	101.6949	A 1	75.0	-0.40	100.6	0.65
2	1	2	2	2	75.69	100	A 2	73.5	1.65	99.2	-0.73
3	1	3	3	3	75.67	100	A 3	75.7	-1.25	100.0	0.08
4	2	1	2	3	75.66	100	B 1	75.0	-0.39	100.6	0.65
5	2	2	3	1	75.83	100	B 2	75.7	-1.30	100.0	0.08
6	2	3	1	2	69.04	97.56097	B 3	73.5	1.69	99.2	-0.73
7	3	1	3	2	75.69	100	C 1	72.8	2.59	99.8	-0.17
8	3	2	1	3	75.63	100	C 2	75.7	-1.27	100.0	0.08
9	3	3	2	1	75.73	100	C 3	75.7	-1.32	100.0	0.08
							D 1	75.1	-0.49	100.6	0.65
							D 2	73.5	1.70	99.2	-0.73
			TOTAL		673	899	D 3	75.7	-1.21	100.0	0.08
			AVERAGE		74.7	99.9		74.7	-0.00	99.9	0.00
			MAXIMUM		75.83	101.6949		75.7	2.59	100.6	0.65
			MINIMUM		69.04	97.56097		72.8	-1.32	99.2	-0.73

OPERATION PROFILE

NAME P HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 2

PCN/NSN/PN 30241A WCD CAEBOS ✓ WCD DATE 89033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPCA	IN DATE	1.0	TRANSIT											NO BATCHING DELIVERED IN GROUPS OF 2 TO 15. LEFT ON TABLE, NO PAPERWORK
				SETUP											
				PROCESS											
50		WELD	1.0	TRANSIT											ALT. OC NO'S ARE: 5700, 5718, 5719, 5721, 5722, 4906, 4647, 5802, 5801, 4908
				SETUP											
				PROCESS	—	—	WG 10	1	100	.50	OC4907	1	100	.50	
55		WELD	1.0	TRANSIT											NOTE ALT. OC NO'S IN OP 50.
				SETUP											REPLACE ENDS ON CAPACITORS (COILS)
				PROCESS	—	—		1	100	.25	OC4907	1	100	.25	
56		CHK	1.0	TRANSIT											TANK IS WATER, PRESSURE CHECK WITH NITROGEN. NO OC NO. ON TANK.
				SETUP											
				PROCESS				1	100	.17	TANK	1	100	.25	LEAK TEST
360		WELD	1.0	TRANSIT											SEE ALT. OC NO'S IN OP. 50
				SETUP											
				PROCESS				1	100	.50	OC4907	1	100	.50	

OPERATION PROFILE

NAME P Hunt ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 2

PCN NSN P/N 30241 A WCD CAEB05 WCD DATE 89033

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
361	MATPCA	CHK	1.0	TRANSIT											TANK IS WATER. PRESSURE -- CHECK WITH NITROGEN. NO BE NA ON TANK. LEAK TEST
				SETUP											
				PROCESS			WG10	1		.17	TANK	1		.17	
9999	↓	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

LSC-20092C

OPERATION OFILE

NAME P. HUNT ALC OKC DATE 8-10-89 RCC MATPRA SHEET 1 OF 1

PCN 35023A WCD CAEY10 WCD DATE 89175

PNI

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPRA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
110		WELD	1.0	TRANSIT											ALT. NO'S ARE 4907, 5718, 5719, 5721, 5732, 4906 4647, 5802, 5801, 4908
				SETUP											
				PROCESS	—	—	WG10	1	100	.50	OC OC5720	1	100	.50	
340		WELD	1.0	TRANSIT											SEE ALT OC NO'S IN OP NO. WELD COVERS.
				SETUP											
				PROCESS	—	—		1	100	.50	OC5720	1	100	.50	
3150		CHK	1.0	TRANSIT											PRESSURE CHK IN WATER TANK WITH NO OC NO. USES !! NITROGEN. TIME INCLUDES REWORK.
				SETUP											
				PROCESS	—	—		1	100	.17	TANK	1	100	.50	
999		OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											

LSC-20092C

OPERATION PROFILE

NAME P HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

PCN/NSN/PN 38694A WCD CAEMO9 WCD DATE 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MARRA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
115		WELD	1.0	TRANSIT			WG70								ALT. NO'S. ARE 4907, 5720 5719, 5721 5722 4906 4641 5802 5801 4908
				SETUP											
				PROCESS				1	100	.17	0C5719	1		.17	
999		OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

OPERATIONS FILE

NAME: r. Hunt A/C: OKC DATE: 8-10-09 RCC: MATPCA SHEET 1 OF 1

NSN / PN: 38718A WCD: CAEMIO WCD DATE: 88239

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPCA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
175		WELD	1.0	TRANSIT											ALT OC NU'S ARE 4907, 5720, 5718, 5719, 5721, 4906, 4647 5802, 5801, 4908
				SETUP											
				PROCESS	—	—	W610	1	100	.5	0C5772	1	-	.5	
255		WELD	1.0	TRANSIT											SEE ALT OC NU'S IN OP175
				SETUP											WELD COVER, ...
				PROCESS	—	—	W610	1	100	.67	0C5772	1		.67	
256		CHK	1.0	TRANSIT											WATER TANK HAS NO OC NO; PRESSURE CHECK USING NITROGEN
				SETUP											
				PROCESS	—	—	W610	1	100	.17	TANK	1	100	.17	
999		OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											

LSC-200226

OPERATION FILE

NAME P. Hunt ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

SCIN / NSN / PN 49315A WCD CAEY09 WCD DATE 88307

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW (HOURS) %	MANDATORY FLOW (HOURS) HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPCA	IN DATE		TRANSIT											
				SETUP											
				PROCESS											
105	MATPCA	WELD.	1.0	TRANSIT											ALT. NO'S ARE 4907, 5720 5718, 5719, 5721, 5722, 4647, 5802, 5801, 4908
				SETUP											
				PROCESS	—	—	WG10	1	100	2.0	0C4906	1	100	2.0	
999	MATPCA	OUT DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											
				TRANSIT											
				SETUP											
				PROCESS											

UPERATIC PHOFILE

NAME P. Hunt ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

PCN
NSN 49711A WCD CAEC07
PNI WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/ LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPCA	IN DATE		TRANSIT											
				SETUP											
				PROCESS											
55	MATPCA	WELD	1.0	TRANSIT											ALT OC NO'S ARE: 4907, 5720, 5718, 5719, 5721, 5722, 4647, 5802, 5801, 4908
				SETUP											
				PROCESS	—	—	WG10	1	100	.67	OC4906	1	100	.67	WELD EXTENSION STRIPS ONTO UNDERSTRUCTURE
70	MATPCA	WELD	1.0	TRANSIT											SEE OP. 55 FOR ALT. OC NO'S
				SETUP											WELD FILTER AND CONNECTIONS
				PROCESS	—	—	WG10	1	100	.25	OC4906	1	100	.25	
270	MATPCA	WELD	1.0	TRANSIT											SEE OP. 55 FOR ALT. OC NO'S.
				SETUP											WELD LID TO EXCITER
				PROCESS	—	—	WG10	1	100	.50	OC4906	1	100	.25	
271	MATPCA	CHK	1.0	TRANSIT											WATER TANK HAS NO OC NO.
				SETUP											USE NITROGEN TO PERFORM LEAK TEST. TIME INCLUDES AVG. REWORK.
				PROCESS	—	—	WG10	1	100	.17	TANK	1	100	.17	

OPERATION PROFILE

NAME P. HUNT ALC OKC DATE 8-10-89 RCC MATPCA SHEET 1 OF 1

NSN/PN 98001A. WCD CAEC07 WCD DATE 89045

OPERATION NUMBER	RCC	OPERATION DESCRIPTION	MANDATORY OCCURRENCE FACTOR	OPERATION TYPE	MANDATORY FLOW HOURS %	MANDATORY FLOW HOURS HRS.	MANPOWER SKILL CODE/LEVEL	MANPOWER QTY.	MANPOWER TIME REQUIRED %	MANPOWER TIME REQUIRED HRS.	EQUIPMENT CODE	EQUIPMENT QTY.	EQUIPMENT TIME REQUIRED %	EQUIPMENT TIME REQUIRED HRS.	DATA SOURCE COMMENTS
	MATPCA	IN DATE	1.0	TRANSIT											
				SETUP											
				PROCESS											
55	MATPCA	WELD	1.0	TRANSIT											ALT OC NO'S ARE: 4907, 5720, 5718, 5719, 5721, 5722, 4906, 5802, 5801, 4908
				SETUP											
				PROCESS	–	–	WG10	1	100	.67	OC4967	1	100	.67	
70	MATPCA	WELD	1.0	TRANSIT											SEE ALT. NO'S IN OP. 55 WELD FILTER AND ... CONNECTORS.
				SETUP											
				PROCESS	–	–	WG10	1	100	.67	OC4967	1	100	.67	
270	MATPCA	WELD	1.0	TRANSIT											SEE ALT. NO'S IN OP. 55 WELD LID TO EXCITER.
				SETUP											
				PROCESS	–	–	WG10	1	100	.50	OC4967	1	100	.50	
27.1	MATPCA	CHK	1.0	TRANSIT											WATER TANK HAS NO OC NO.; LEAK CHECK USING NITROGEN.
				SETUP											
				PROCESS	–	–	WG10	1	100	.17	TANK	1	100	.17	

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 89-037F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC OC DATE 05/13/89
RCC MATPCA ITEM NO. —
NOUN "General Suggestion"

(IO # 3

CURRENT METHOD

Much of the present testing equipment found in the MATPCA work areas are outdated and exibit long down-times for repair. Both the technicians and the first line supervisory personnel express dissatisfaction with this equipment.

PROPOSED METHOD

A detailed study of the testing equipment should be performed in conjunction with an analysis of the forecasted demand of the presently worked items. If economically feasible, the testing equipment should be replaced with newer, more generalized testing equipment.

BENEFIT OF CHANGE

The benefits would be threefold:
(A) faster, more accurate testing of the individual items.
(B) Reduced down-time and lower maintenance costs of test equipment.
(C) more effective use of skilled employees times.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 201114

COST BENEFIT CALCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(________ DELTA COST) (________ 12 MO. SCHEDULE) = ________ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(________ DELTA COST) (________ 5 YR PROJECTION) = ________ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 89-036F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC DC **DATE** 05/13/89
RCC MATCA **ITEM NO.** –
NOUN "General Suggestion"

PIO #4

CURRENT METHOD

Several replacement parts shipped from outside manufacturers have been noted to have high failure rates after installation. Many of these items are electrical parts used in the accesory units worked by the MATPCA area. These electrical parts have a high damage potential from moisture, and several cases of improper packaging at the factory have been blamed for these failures.

PROPOSED METHOD

A parts tracking procedure should be designed and implemented that would identify the number and origin of failed parts drawn from new stock. This could easily be done by installing the appropriate data processing system into the existing system, and noting occurences of failures at the existing computer terminals already in place (notably the supervisors offices).

BENEFIT OF CHANGE

The benefits of this system, especially if incorporated into a large number of USAF support operations, could prove to be immense. The present system depends solely on the reporting of incidence of abnormal failure rates by the technicians themselves.

PRODUCTIVITY IMPROVEMENT SUMMARY

SER‹ ‹ES PROGRAM

COST BENE‹ ‹ ‹CULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 8-1-54F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

ALC OC DATE 5/8/89
RCC MATPCA ITEM NO. —
NOUN General Suggestion

PHIL PARKER

PIO # 5

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

CURRENT METHOD

Long delay times are occurring in backshop (specifically MATPCM and MATPIW) operations on items sent from MATPCA electrical repair unit. Time spent at backshop areas ranges from 24.0 - 72.0 hours. (These delays are seen in other backshop operations involving other RCCs).

PROPOSED METHOD

A detailed analysis of delivery schedules, operation times, and idle time after work completed should be performed. This data should be compared to revised and updated demand schedules for each item sent to back shop.

BENEFIT OF CHANGE

This analysis is important so that we may effectively streamline all operations for a particular end item, as well as provide a quicker response time for return to inventory (critical in a defense industry) of critical parts. It would allow increased productivity and more effective utilization of existing facilities and staff.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 70131A

SER. ..ES PROGRAM

COST BENL .T LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

ISC-20131A

TECHN... GY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 8 - 36F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC Oc DATE 5/16/89
RCC MATPCA ITEM NO. —
NOUN General Suggestion

Phil Parker

PIO # 9

CURRENT METHOD

Many of the items worked in this RCC have RTV or potting compound used to anchor internal components as well as provide insulation. These materials are tedious to remove, requiring a great deal of skilled technician's time.

PROPOSED METHOD

A study should be performed to determine whether formed rubber housings or sheets could be substituted for the presently used RTV or potting compounds. Also, the use of phenolic blocks formed to hold components in place should be analyzed.

BENEFIT OF CHANGE

A great deal of time and effort could be reduced on the targeted electrical items if these suggested methods prove feasible. More effective use of resources and skilled technicians would occur.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20131A

SE. CES PROGRAM

COST BENL .f .LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 81-057F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☒ OTHER Health & Safety

ALC OC DATE 05/13/89
RCC MAT PCA ITEM NO. –
NOUN "General Suggestion" - ALC wide

Phil Arker

PIO # 12

CURRENT METHOD

Several different types of hand tools have been observed in use in the Electrical Components Overhaul RCC (MATPCA). Many of these tools do not conform to presently recommended occupational Ergonomic - Human Factors standards

PROPOSED METHOD

The replacement of many of the presently used hand tools, both manual and power, by ergonomically sound designs would increase worker efficiency by decreasing fatigue and wasted effort, as well as reduce the costs of worker compensation claims and lost time due to injury.

BENEFIT OF CHANGE

A great deal of information has been collected in recent years pertaining to the effects that incorrectly designed tools have on industrial workers. Decreased productivity as well as debilitating illnesses such as Carpal Tunnel Syndrome and reoccurring Tendonitis have been clearly demonstrated. These problems are easily corrected by selection of the proper tool designs (See attached data).

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20131A

SER ES PROGRAM

COST BENE ... LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 87-US8F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL
- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC OC DATE 5/15/89
RCC MATPCA ITEM NO. —
NOUN General suggestion

Phil Parker

PID #15

CURRENT METHOD

Presently, an old refrigerator packed with dessicant is being used as a humidity control chamber. Many of the internal components of items worked in this RCC have a high damage potential from moisture exposure.

PROPOSED METHOD

The presently used system is very inadequate given the needs of this RCC. A specifically designed humidity control chamber should be purchased for use in this area.

BENEFIT OF CHANGE

A much lower rate of moisture damaged components, as reported by the individual technicians, would be seen. This would save restocking costs of damaged components, as well as reduce costs of repeated repairs due to damage

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20131A

SERV. ES PROGRAM

COST BENE. . . . LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(____ DELTA COST) (____ 12 MO. SCHEDULE) = ____ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(____ DELTA COST) (____ 5 YR PROJECTION) = ____ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ____	$ ____
IMPLEMENTATION COSTS	- ____	- ____
NET SAVINGS	$ ____	$ ____

LSC 20131A

TECHN... GY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 6 - 59F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC OC DATE 5/15/89
RCC MATPCA ITEM NO. 35113A
NOUN Control Relay Box

Phil Parker

PIO # 16

CURRENT METHOD

The amplifier assy. for this control box is not carded any repairable time, even though existing technicians report that they can usually repair the component.

PROPOSED METHOD

This amplifier assy. should be made a repairable item with standard overhaul time assigned to this task.

BENEFIT OF CHANGE

Technicians report that the replacement costs for this item is $2,700.00. While a detail cost analysis has not yet been authorized, savings of repair vs. replacement of each component should be significant.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 201...

SER...ES PROGRAM

COST BENE... LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

TSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 87-160F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC OC DATE 5/15/85
RCC MATPCA ITEM NO. –
NOUN General Suggestion

Phil Parker

PIO # 17

CURRENT METHOD

Many internal components for items worked by this RCC are not assigned repairable time. Many of these components could be repaired by existing skilled technicians.

PROPOSED METHOD

A detailed cost analysis should be performed on repair vs. replacement of individual internal components on a variety of items worked by this RCC.

BENEFIT OF CHANGE

The cost savings possible in this analysis may prove very attractive given present economic considerations.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20111A

[illegible] INSERTION ENGINEERING
SERV... S PROGRAM

COST BENEF... ..LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 89-061F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER ______

ALC OC DATE 5/15/85
RCC MATRA ITEM NO. 35111A
NOUN Auto. Ignition Actuator

PHIL Parker

PEO # 18

CURRENT METHOD

Presently, if the switch assembly in the cover housing is inoperative, the entire housing assembly must be replaced at a cost of $800.00 per assembly. The switch is installed into the housing using a special potting compound, which is unavailable from the vendor.

PROPOSED METHOD

Technicians report that if given the potting compound, they can replace the switch at a cost of ~$100.00.

BENEFIT OF CHANGE

As stated, if the potting compound can be acquired from Bendix, who also produces the cover housing, the cost benefit would be approximately $700.00 per item worked.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 2013

TEC[illegible]GY INSERTION ENGINEERING
SER[illegible]ES PROGRAM

COST BENEF[illegible] C[illegible]CULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-062F

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

☐ QUICK FIX
☒ FOCUS STUDY
☐ OTHER ______

ALC OC DATE 5/25/89
RCC MATPCA ITEM NO. 34252A
NOUN Flowmeter Pwr. Supply

PHIL Parker

PIO #19

CURRENT METHOD

Presently, the internal circuit boards are not coded any time for repair although technicians are capable of performing these repairs at a relatively low cost in man hours.

PROPOSED METHOD

A focus study should be performed using a detailed cost analysis of the cost benefit of repairing the internal circuit boards of this item vs. replacement of the board assembly.

BENEFIT OF CHANGE

Possible benefits include lower overhaul costs with subsequent savings being utilized in other critical areas.

PRODUCTIVITY IMPROVEMENT SUMMARY

TECH[illegible]GY INSERTION ENGINEERING
SERVI[illegible] PROGRAM

COST BENEFIT CALCULATIONS

OLD METHOD

DESCRIPTION	[illegible] / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL CO[illegible]		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-70131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF7

TYPE PROPOSAL

- ☒ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ____

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

BOB BUTTRY

ALC ALL DATE 13 JUN 89
RCC ALL ITEM NO. ____
NOUN INSPECTION

CURRENT METHOD: QDR'S ARE WRITTEN DESCRIBING KNOWN DISCREPANCIES ON PARTS IN STORAGE. THE STORE'S MANAGER DECIDES ON HIS OWN INITIATIVE IF A PART SO DESCRIBED AS POTENTIALLY DISCREPANT WILL OR WILL NOT BE INSPECTED (SCREENED) FOR THE NOTED QDR DISCREPANCY PRIOR TO RELEASING THESE PARTS FROM THE STORAGE AREA. THIS AFFECTS PRODUCTIVITY AS BAD PARTS ARE FIRST DISCOVERED ON THE PRODUCTION FLOOR.

PROPOSED METHOD: REQUIRE ALL PARTS IN STORES TO BE SCREENED FOR QDR NOTED DISCREPANCIES ACCORDING TO A SET CRITERIA RELATING TO THE NUMBER OF PARTS OR THE NUMBER OF TIMES A PART IS FOUND TO BE DISCREPANT ON THE PRODUCTION FLOOR.

BENEFIT OF CHANGE: PRODUCTIVITY WILL NOT BE IMPACTED IF DISCREPANT PARTS ARE REMOVED FROM STORES BEFORE SENDING THESE SCREENED PARTS TO THE PRODUCTION FLOOR.

PRODUCTIVITY IMPROVEMENT SUMMARY: DOWNTIME AND FLOWTIME WILL BE REDUCED BY REMOVING DISCREPANT PARTS FROM SUSPECT LOTS OF PARTS IN STORAGE PRIOR TO SENDING THESE PARTS INTO PRODUCTION.

LSC-[illegible]

REQUESTED COST DATA FOR RRB-QF7

Cost Savings:

Present Condition Cost For the Last 12 Months:

Rework costs associated with repairing supplier parts received from stores and delivered to the production RCC when the noted reason for repair is already documented on a QDR = $_______.

Scrap costs for parts associated for the above = $_______.

Return to supplier (stores) costs for parts associated with the above = $_______.

Labor costs associated with the above parts = $_______.

Proposed Implementation Cost:

Costs either to return or to screen all parts in stores identified as discrepant on a QDR = $_______.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = $_______.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-OF4

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

BOB BUTTRY

ALC COMMAND WIDE **DATE** 19 JUN 89
RCC ALL **ITEM NO.** ______
NOUN UNCONTROLLED TECH ORDERS

CURRENT METHOD: MECHANICS WORK TO TECH ORDER REQUIREMENTS AS REFERENCED PER WCD INSTRUCTIONS. THE TECH ORDERS ARE USUALLY UNAUTHORIZED AND UNCONTROLLED COPIES THAT THEY KEEP HANDY AT THEIR WORK STATIONS. THESE COPIES ARE SUBJECT TO BEING OUT-OF-DATE AT ANY TIME. THE MECHANICS MAKE NEW COPIES FOR THEIR USE WHEN "WORD OF MOUTH" INFORMS THEM THAT A TECH ORDER REVISION HAS BEEN ISSUED.

PROPOSED METHOD: REPLACE ALL TECH ORDER MANUALS WITH PAPERLESS, COMPUTER GENERATED, ELECTRONICALLY UPDATED, CRT-AVAILABLE TECH ORDERS. LOCATE THE CRT'S SO THAT THEY ARE CONVENIENT AND ACCESSIBLE TO ALL MECHANICS. KEEP THE TECH ORDERS UPDATED SO THAT THE MECHANICS WILL ALWAYS HAVE ACCESS TO THE MOST CURRENT PROCEDURES.

BENEFIT OF CHANGE: (1) REPAIRED PARTS WILL ALWAYS BE DONE TO THE CORRECT CONFIGURATION AND PROCEDURE. (2) TECH ORDER MANUALS WILL NOT REQUIRE PERIODIC, TIME CONSUMING UPDATING. (3) TECH ORDER UPDATES WILL OCCUR SIMULTANEOUSLY THROUGHOUT ALL THE ALC'S.

PRODUCTIVITY IMPROVEMENT SUMMARY: (1) PERSONNEL WHO USED TO UPDATE TECH ORDER MANUALS CAN BE RETRAINED FOR OTHER DUTIES. (2) PARTS THAT FORMERLY WERE REPAIRED TO OUT-OF-DATE PROCEDURES WILL NOT HAVE TO BE REDONE.

REQUESTED COST DATA FOR RRB-QF4

Cost Savings:

Present Condition Cost For the Last 12 Months:

Rework and scrap costs associated with mechanics repairing parts to unauthorized/uncontrolled copies of technical orders = $_______.

Cost to print, distribute and incorporate all changes to the technical orders = $_______.

Proposed Implementation Cost:

Cost involved to install CRTs on the production floor so that all mechanics will have convenient access to a CRT = $_______.

The special data processing cost required to initiate/implement this system = $_______.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = $_______.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF2

TYPE PROPOSAL

- [x] **QUICK FIX**
- [ ] **FOCUS STUDY**
- [ ] **OTHER** ______

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

BOB BUTTRY

ALC COMMAND WIDE **DATE** 19 JUN 89
RCC ALL **ITEM NO.** ______
NOUN NEW PART IDENTIFICATION

CURRENT METHOD: USUALLY, ONLY THE OUTER PACKAGING OF NEW PARTS HAS THE SUPPLIER'S CONTRACT NUMBER, VENDOR CODE, AND DATE OF MANUFACTURE. THIS IDENTIFICATION MAY BE LOST IF THE PART IS REMOVED FROM ITS OUTER PACKAGING IN ORDER TO BE STAGED FOR INSTALLATION. IF, DURING INSTALLATION, A PART IS FOUND TO BE DISCREPANT, A QDR MAY NOT RESULT IN SUPPLIER CORRECTIVE ACTION DUE TO THE LACK OF ANY OF THIS I.D. INFORMATION ON THE QDR.

PROPOSED METHOD: MANDATE A GENERAL CONTRACT P.O. REQUIREMENT THAT THE ABOVE 3 PIECES OF I.D. BE AFFIXED TO EACH PART BY THE SUPPLIER PER AN ACCEPTABLE METHOD. THE P.O. SHOULD ALSO STIPULATE THAT THE PART(S) MAY BE RETURNED TO THE SUPPLIER WHENEVER THE OUTER PACKAGE IS OPENED AND THE NOTED I.D. INFORMATION IS MISSING.

BENEFIT OF CHANGE: (1) SUPPLIERS WILL BE REQUIRED TO TAKE CORRECTIVE ACTION FOR EVERY SUPPLIER RELATED QDR. (2) ALL SUPPLIER RELATED QDR'S WILL BE ANSWERED IN A TIMELY MANNER. (3) NO PARTS STILL UNDER WARRANTY WILL BE SCRAPPED OR REPAIRED AT THE EXPENSE OF THE ALC.

PRODUCTIVITY IMPROVEMENT SUMMARY: THERE WILL BE LESS DOWNTIME FROM RECURRING DISCREPANCIES FOR NEW PARTS AS SUPPLIERS ARE REQUIRED TO ACCEPT THE RESPONSIBILITY FOR CORRECTIVE ACTION ON QDR'S WITH PROPERLY DOCUMENTED PART IDENTIFICATION.

REQUESTED COST DATA FOR RRB-QF2

<u>Cost Savings:</u>

Cost Improvement Data:

Present Condition Cost For the Last 12 Months:

Cost to replace all new purchased parts that were scrapped at the expense of the ALC due to the lack of necessary supplier I.D. at installation = $_______.

Cost to repair all new purchased parts at the expense of the ALC due to the lack of necessary supplier I.D. at installation = $_______.

Proposed Implementation Cost:

Cost incurred by ALC purchasing office to insert the noted P.O. requirement (ref. "Proposed Method," page 1) = $_______.

Estimated additional annual cost by all ALC new parts suppliers to implement the noted I.D. requirement as specified (ref. "Proposed Method," page 1) = $_______.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = $_______.

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-QF1

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☒ **QUICK FIX**
- ☐ **FOCUS STUDY**
- ☐ **OTHER** ______

ALC COMMAND WIDE **DATE** 19 JUN 89

RCC ALL **ITEM NO.** ______

NOUN NEW PART WARRANTIES

BOB BUTTRY

CURRENT METHOD: SUPPLY RECEIVES AND STORES NEW SUPPLIER PARTS FOR SUBSEQUENT DISTRIBUTION AND USAGE BY ALC SHOPS. NO STOCK ROTATION METHOD IS BEING USED TO ASSURE A "FIRST IN - FIRST OUT" DISTRIBUTION OF THESE PARTS. NEW PARTS HAVE A WARRANTY THAT IS VALID FOR A SPECIFIED PERIOD OF TIME. THIS WARRANTY BECOMES VOID WHEN DISCREPANT NEW PARTS ARE NOT DISCOVERED WITHIN THIS TIME PERIOD.

PROPOSED METHOD: TO AVOID THE ABOVE, SUPPLY SHOULD DATE STAMP EVERY PART, OR THE OUTER PACKAGE OF EVERY PART, AS IT IS RECEIVED. SUPPLY SHOULD THEN STORE AND ROTATE THE NEW PARTS STOCK SO THAT THE OLDEST DATE STAMPED PART IS ISSUED TO THE PRODUCTION SHOP FIRST.

BENEFIT OF CHANGE: (1) SUPPLIERS OF DISCREPANT PARTS UNDER WARRANTY WILL BE REQUIRED TO REPLACE OR REPAIR THEM AT NO COST TO THE ALC, OR IN ACCORDANCE WITH THE WARRANTEE TERMS. (2) THE DISCOVERY OF NUMEROUS DISCREPANT PARTS WITHIN A CONTRACT LOT USUALLY ALLOWS THE ALC TO RETURN THAT ENTIRE LOT TO THE SUPPLIER FOR PARTS SCREENING AND SUBSEQUENT REPLACEMENT OR REPAIR AT THE SUPPLIER'S EXPENSE. (3) SUPPLIER CORRECTIVE ACTION BECOMES MORE TIMELY, RESPONSIVE, AND EFFECTIVE. (4) UNRELIABLE SUPPLIERS ARE ELIMINATED EARLY-ON.

PRODUCTIVITY IMPROVEMENT SUMMARY: CYCLE AND FLOW TIMES BECOME REDUCED WHEN MECHANICS NO LONGER MUST REPAIR NEW PARTS PRIOR TO USING THEM.

REQUESTED COST DATA FOR RRB-QF1

Cost Savings:

Present Condition Cost For the Last 12 Months:

(A) Cost of scrapping all new purchased parts at the expense of the ALC due to expired warranties = $______________.

(B) Cost of repairing all new purchased parts at the expense of the ALC due to expired warranties = $______________.

Proposed Implementation Cost:

Labor costs involved to date stamp the new purchased parts and rotate the oldest stock forward during the storage of new parts = $________.

Annual Cost Savings (First Year):

[Present Condition Cost] - [Proposed Implementation Cost] = $________.

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 81-088

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC OC DATE 05/19/89
RCC MATPCA ITEM NO. 97133A
NOUN Electromag 3-way select valve.

Phil Parker

PIO # 13

CURRENT METHOD

Most of these items have one port blocked off. They are used for hot air bleed-off purposes. Origonally, the third port was used for fuel transfer. When overhauled, the item is required by technical order to be tested on the fuel transfer test stand in building 3108.

PROPOSED METHOD

Since the item is no longer used in its origonally designed manner, and the third port (fuel) is blocked off by the purchasing organization, the required testing procedure should be deleted.

BENEFIT OF CHANGE

By deleting the unnecessary test, turnaround on this item would be shortened by one hour for each individual 3-way select valve. This would free skilled technicians for other duties, free testing equipment for other uses, and otherwise reduce operating expenses.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 7911

SERVIC[illegible] ROG[illegible]AM

COST BENEFIT CALCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	______	______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. 89-011Q

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC OC DATE 05/05/89
RCC MATPCA ITEM NO. 38669A
NOUN Ignition Exciter Leak check.
OPN # 123

PIO # 2

CURRENT METHOD

The ignition exciter unit is filled with high pressure Nitrogen gas and heated in an oven. After the unit is cooled it is placed in a water bath to check for leakage. The water bath must be at a specific temperature (?) to perform the test. It was noted that shop personnel routinely reduce the bath's temperature to prevent the water level from evaporating.

PROPOSED METHOD

It is suggested that the installation of an insulated cover on the existing water bath would maintain required heat while subsequently reducing the evaporation rate of the bath.

BENEFIT OF CHANGE

As the above described leak test is a one minute operation, and the heating time required for the water bath is ~ 15-20 minutes, it would appear that operator productivity would be enhanced significantly by maintaining the water bath's temperature at or near the optimal test range. The proposed change should be relatively inexpensive with no impact on work load occurring.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC-20131A

SE... ...UCT INSLITION ENGINEERING PRC... IAM

COST BEN... ...LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

ISC-70131A

TECHNOLO... INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 81-...1Q

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- ☒ QUICK FIX
- ☐ FOCUS STUDY
- ☐ OTHER ______

ALC DC DATE 5/15/89
RCC MATPCA ITEM NO. 97133A
NOUN Electromag 3-way valve

Phil Parker

PIO # 14

CURRENT METHOD

No specific requirement for testing this item with compressed air before it is placed on the fuel transfer station now exists. Operator preference is the determinant as to WHETHER this operation is performed.

PROPOSED METHOD

Initial leak testing with compressed air before placement on the fuel transfer station should be made a specified requirement for this valve. (This is dependent on outcome of PIO control number suggestion, which deletes the fuel transfer testing procedure entirely)

BENEFIT OF CHANGE

By testing the valve assembly with compressed air, and thereby determining ~~rather~~ whether leaks actually exists, the possibility of lost time in transportation and set-up on the fuel transfer equipment will be removed.

PRODUCTIVITY IMPROVEMENT SUMMARY

SERV PROGRAM

COST BENEFIT CALCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-__10

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC OC DATE 5/10/89
RCC MATPCA ITEM NO. 38645A
NOUN TEMP AMPLIFIER

Phil Parker

PIO # 7

CURRENT METHOD

The A3 module of this item requires approximately 9.0 hours to remove and replace. This is due to it being a "select fit" component. This means that the electrical specifications and tolerances must be determined through testing before installation can occur.

PROPOSED METHOD

Technicians report that when the individual specifications for an A3 module are provided by the vendor, they have tested within limits at this installation. It is therefor suggested that all A3 modules have their factory determined specifications sent with them to this RCC.

BENEFIT OF CHANGE

Technicians report that by utilizing the factory specifications of the A3 module, and thereby deleting the initial testing procedures, installation time can be reduced from 9.0 hours to 3.0 hours for this component. Turnaround to Air Force inventory is shortened, more effective use of existing resources is accomplished, and more productive use of skilled technicians can occur.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20171A

SER. PRC RAM

COST BENE LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
				TOTAL COST		

NEW METHOD

DESCRIPTION	STD. HRS / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC-20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. ______

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC OC DATE 5/19/85
RCC MAT PCA ITEM NO. 61234A
NOUN Ignition Exciter

Phil Parker

PIO # 8

CURRENT METHOD

Presently this item is not targeted as a selective overhaul (MATROC) item. Technicians routinely perform a diagnostic test on this exciter, and they report a 50% failure rate. This failure rate includes replacement of the internal transformer unit for pitting due to arcing damage.

PROPOSED METHOD

By designating this ignition exciter as a MATROC item, and requiring that an initial functional test be performed, it is reasonable to assume that 50% of all items processed would be ready to return to inventory in one to two hours. It is also suggested that a time limit for visual inspection of the internal transformer be set at two to three years intervals (applicable to overhaul facilities.

BENEFIT OF CHANGE

The benefits of this change would include quicker turnaround time and return to A.F. inventory, better utilization of resources and skilled technicians, and reduced operating costs.

PRODUCTIVITY IMPROVEMENT SUMMARY

LSC 20131A

SER. PRC AM

COST BENL CULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:				TOTAL COST		

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 87-..02

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ____

ALC OC DATE 5/16/89
RCC MATPCA ITEM NO. 50217A
NOUN Ign. Exciter

Phil Parker

PEO #10

CURRENT METHOD

This ignition exciter uses a potting compound to anchor the internal components as well as act as an insulator for them. This compound must be chipped out for overhaul purposes.

PROPOSED METHOD

Use of RTV sealant as in the case of other related ignition exciters is suggested.

BENEFIT OF CHANGE

The use of the RTV sealant would expidite internal component removal during overhaul, making better use of present resources and and skilled technician's time.

PRODUCTIVITY IMPROVEMENT SUMMARY

TECH. .OGY INSERTION ENGINEERING
SERVI 'ROGRAM

COST BENEFIT CALCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING
SERVICES PROGRAM

CONTROL NO. 89-039R

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

TYPE PROPOSAL

- [x] QUICK FIX
- [ ] FOCUS STUDY
- [ ] OTHER ______

ALC OC DATE 5/19/89
RCC MATPCA ITEM NO. 50217A
NOUN Ignition Exciter

Phil Parker

PEO # 11

CURRENT METHOD

Presently this item is not targeted as a selective overhaul (MATROC) item. Technicians routinely perform a diagnostic test on this exciter, and they report a 50% failure rate. This failure rate includes replacement of the internal transformer unit for pitting due to arcing damage.

PROPOSED METHOD

By designating this ignition exciter as a MATROC item, and requiring that an initial functional test be performed, it is reasonable to assume that 50% of all items processed would be ready to return to inventory in one to two hours. It is also suggested that a time limit for visual inspection of the internal transformer be set at two to three years intervals (applicable to overhaul facilitie

BENEFIT OF CHANGE

The benefits of this change would include quicker turnaround time and return to A.F. inventory, better utilization of resources and skilled technicians, and reduced operating costs.

PRODUCTIVITY IMPROVEMENT SUMMARY

SE. ... PRO AM

COST BEN ... LCULATIONS

OLD METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

ANNUAL SAVINGS

(______ DELTA COST) (______ 12 MO. SCHEDULE) = ______ 1st YEAR SAVINGS

IMPLEMENTATION COSTS

DESCRIPTION	LABOR COST	MAT'L	O.H. RATE			TOTAL COST
					TOTAL COST	

NEW METHOD

DESCRIPTION	STD. HRS. / PART	COST / HR.	O.H. / HR.			TOTAL COST / PART
NOTES:					TOTAL COST	

EXTENDED SAVINGS

(______ DELTA COST) (______ 5 YR PROJECTION) = ______ TOTAL SAVINGS

SUMMARY

	ANNUAL	ENTENDED
GROSS SAVINGS	$ ______	$ ______
IMPLEMENTATION COSTS	- ______	- ______
NET SAVINGS	$ ______	$ ______

LSC 20131A

TECHNOLOGY INSERTION ENGINEERING SERVICES PROGRAM

CONTROL NO. RRB-FS2

TI PROGRAM
COST BENEFIT ANALYSIS REPORT

BOB BUTTRY

ALC ALL **DATE** 13 JUN 89
RCC ALL **ITEM NO.**
NOUN SCRAP

TYPE PROPOSAL

- ☐ QUICK FIX
- ☒ FOCUS STUDY
- ☐ OTHER

CURRENT METHOD: PRODUCTION OPERATIONS GENERATE SCRAP THROUGH A VARIETY OF CAUSES. THIS SCRAP IS ORDINARILY REMOVED FROM THE RCC FOR DISPOSAL, ALONG WITH THE ACCOMPANYING WCD'S.

PROPOSED METHOD: EACH RCC SHOULD MAINTAIN A SCRAP LOGBOOK THAT LISTS EACH PART AS IT IS SCRAPPED AND THE CAUSE FOR SCRAPPING THE PART.

BENEFIT OF CHANGE: A PERIODIC REVIEW OF AN RCC'S SCRAP LOGBOOK COULD BE USED TO DETERMINE HOW TO REDUCE EXCESSIVE SCRAP BY IMPLEMENTING METHODS TO ELIMINATE, OR REDUCE, THE REPETATIVE CAUSES FOR SCRAPPING PARTS.

PRODUCTIVITY IMPROVEMENT SUMMARY: PRODUCTIVITY IMPROVEMENT IS DIRECTLY RELATED TO REDUCING SCRAP BY CORRECLTY REPAIRING A PART OVER THE SAME TIME PERIOD THAT A PART PREVIOUSLY WAS INCORRECTLY REPAIRED. ALSO, MATERIAL WASTE IS REDUCED BY NOT HAVING TO DISPOSE OF THE SCRAPPED PART. ALSO SAVES COST OF PURCHASING A BRAND NEW REPLACEMENT PART.

REQUESTED COST DATA FOR RRB-FS2

Present Condition Cost for Last 12 Months:

Annual cost associated with maintaining a scrap logbook within each RCC. Each part scrapped must be identified, dated, and the reason for scrap indicated.

Cost of Logbook(s) = $ ___________

Labor Cost for Entries = $ ___________

(

J. CARTER

4-25-89

PIO#1 ON ENTERING AREA (CA) MY FIRST OBSERVATION WAS THE ODOR OF TRI-CHLORETHANE USED AS A DEGREASER. FROM PAST EXPERIANCE, I HAVE FOUND TRI-CHLOR TO BE A DIFICULT CHEMICAL TO WORK WITH. BIO-ACT IS A NATURAL DEGREASER THAT IS BIO-DEGRADEABLE MATERIAL THAT WHEN CONTAMINATED, MAY BE DISPOSED OF BY INCENERATION. TEST EQUIPMENT WAS SOMEWHAT ANTIQUATED, BUT CENTRALLY LOCATED AND EASILY ACCESSABLE BY ALL TECHNICIANS LIGHTING WASE ADEQUATE, AREA WAS CLEAN, AND COMPRABLE TO MOST FABRICATION FACILLITIES. THE TECHNICIANS SEEMED WELL TRAINED & QUITE COMPETANT FOR ASSIGNED TASKS.

4-26-89

PIO#2 OBSERVED PHYSICAL MEASURING OF CASTINGS & MACHINED PARTS. METHODS USED WERE CONVENTIONAL MICROMETERS & STANDARD INSPECTION INSTRUMENTS. THE USE OF A SMALL "CORDAX" (COORDINANT MEASURING) MACHINE WOULD ENHANCE DIMENSIONAL CREDIBILITY.

4-27

OBSERVED EXCESSIVE, MOISTURE INDUCED,
PIO#3 CONTAMINATION OF CASES, RESULTING IN
RE-CLEANING OF CASES. A CLEAN ROOM
ENVIROMENT WOULD ELLIMINATE THIS
CONDITION. HUMIDITY & TEMPERATURE
CONTROL WOULD ENHANCE LONGIVITY
OF THE PRODUCT.

4-28

OBSERVED MULTI-STEP TESTING OF PRODUCT
PIO#4 THIS OPERATION COULD BE IMPROVED
BY THE USE OF A "FAULT FINDER" A CNC TEST
UNIT WITH A PRINT OUT. THIS WOULD
ALSO GIVE TRACEABILITY OF ALL REPAIRS
WITH A PERMINANT RECORD.

5-4-89 OBSERVED EXCESSIVE TRANSIT TIME
PCA TO PCD.
PIO#5 REQUESTS THE TRANSFER OF ONE
/ ARBOR PRESS TO PCA AREA.

5-5-89 ELECTRONIC TEST BENCH # OC 4929 &
OC 3609 WENT DOWN AT APPROX
10:00 HRS & WAS OUT OF SERVICE
WITH APPROX. FIFTY COMPLETED UNITS
PIO#7 AWAITING TEST. A "QUICK FIX" WOULD
BE TO PLACE FIBERGLASS FURNACE
FILTERS ON TOP OF LOUVERED
CABINATES. REDUCING THE AMOUNT
OF CONTAMINATION TO ELECTRONIC
COMPONANTS.

PIO#8 TEST STAND # OC 5507 THIS UNIT
PURCHASED AT COST APPROX $1.3 MIL.
IS MARGINALY FUNCTIONAL (5%)
AND IS NOT COST EFFECTIVE
(1.0 MAN HRS TO TEST EXCITERS)

(PIO # 8 CONT.)

SIMMONS, THE O.E.M., HAS A SIMPLE TEST STAND THAT CONDUCTS THE SAME TESTS IN SEVEN MIN. WITH A PRINT OUT FOR Q.A. RECORDS.

ENG NOTES 5-3-89 MAT PCA PAGE#4

P10#6 WHILE OBSERVING A TEST OPER, I CHECKED THE PREVENTIVE MAINT & CALIBRATION ON THE FOLLOWING TEST ITEMS:

OC 3952	NITROGEN LEAK TEST	20 SEPT 78
OC 3952	ELEC TEST BENCH	4-21-89
OC 3953	" " "	7 APR 86
OC 4929	" " "	6-7-86

OVENS (4 EA) MAINT ONLY AT BREAKDOWN OIL SIGHT GAGE IMPOSSIBLE TO SEE - YEARS OF STAIN BLACKENED THE UNIT. TECHNICIANS HAVE NOT BEEN INSTRUCTED ON DAILY MAINT. REQUIREMENTS.
OBSERVED WCD ON 350234 NOT TO ACT METHOD. SUGGEST PLANNERS CONSULT TECHNICIANS TO VERIFY SEQUENCING & METHODS

ENG. NOTES: JACK CARTER

5-2-89

PCN 42590 FLOW CHART
OP 010 & 015 - REC & VERIFY
P/A#5 OP 020 BREAK SOLDER SEAL ON CASE - OPEN DIG OUT EPOXY-FOAM - NOTE - EVRY EFFORT SHOULD BE MADE TO DELETE THIS OPER. IT IS VERY LABOR INTENSIVE & NOT COST EFFECTIVE.
030 MOVE TO TRICHLOR TANK FOR CLEANING
040 VISUAL INSPECTION AT WORK BENCH
OP 060 THRU 120 - ELECTRICAL TESTING DONE AT TEST STAND - IDENTIFY SUB-STANDARD PARTS
380 REPAIR OR REPLACE PARTS AS REQ'D.
390 REASSEMBLE ALL COMPONIAN

PCN 37719A AUTOMATIC PILOT - 48 UNITS PER MO. NOTE: THIS OPER WILL BE PHASED OUT OVER THE NEXT TWO TO THREE YEARS - AREA WAS WELL LIGHTED, OPERATOR COMPETANT & WELL TRAINED EQUIPMENT ADEQUATE TO THE PRODUCT REQUIREMENTS.

Philip J Farmer

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA (30053A)	RCC
05/04/89	Interview performed with Wendel Hawkins. Described rework of combox assy. While not specifically noted as an operation on the WCD, the requirement to disassemble (and all related operations) is determined by the results of an initial diagnostic test of the combox unit. If the item checks out OK, the switch is replaced and aligned, and the unit is typically cleaned and released for use. Switch replacement, adjustment, and cleaning procedures take ~20 minutes to perform. All work is done at technicians bench, with specialized testing equipment and tools being checked out from a central tool bin located in the unit. If a disassembled part is out of tolerance, it is replaced with new parts. Two main testers are used, and both are portable units (only two in unit): (1) Switch adjustment device (SA120) (2) Dial Indicator (DI110) Total time reported: 2.52 hr/unit Total time allowed: ? Note: Possibility of lower grade "test technician" to perform initial test procedure, route tested items to rework technician or inventory as required.	MATPCA
05-04-89 PIO #1	Suggest the creation of a primary "initial tester" of the combox assy unit. This individual could be at a lower grade level, and be responsible for routing the unit to the overhaul technician if required or performing the shorter refitting task if test is OK. Benefits: Quicker turnover and return to inventory, better utilization of skilled overhaul techs.	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
05/05/89	Interview with Larry Ware (WG-10) on Ignition Exciter (38669A) rework. Unit requires several test procedures (see opn. profile). After the initial cleaning, inspection, and testing, the unit is hand-carried to the machine shop (MATPEM) or the mechanic for lid removal. Note that only one machine is normally designated for this task, and that the unit will normally remain at MATPEM for 24 hrs until it returns to MATPCA. The unit is then dissassembled, inspected, and several internal items are [illegible]. Parts are removed and replaced as required. After reassembly and testing, the unit is hand-carried to the welding shop (MATPIW) by the mechanic, and the lid is welded on. Time at MATPIW is ~ 24 hr.	MATPCA
	Note: It appears that rebuild kits are normally ordered (by regulation) only when units are received. This can cause up to 2 day delay for kit receival into unit. Technicians are ordering extra kits to avoid this.	
	Note: If the filter assy (opn 85) is bad, very long delay ( ) due to backshop ( ) turnaround.	
	Note: If items replaced with new replacement items, then no requirement to test unit for specific item function. Technicians note high rate of failure of new items (suggest study of actual reliability of new items?). Technicians are presently performing tests.	
	Note: water bath being adjusted down to prevent evaporation. Requires ~15-20 minutes to reach optimal heat.	

PIO #2 Suggest the installation of a lid on water bath to reduce evaporation while maintaining heat at operational level.

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/8/69	Interview with Larry Ware on PCI 49711A. An initial test is performed on this unit. If the test is OK the unit is routed to inventory. If the unit fails it is routed to overhaul. There is a ~50% failure rate.	MATPCA
	Note: If the housing must be extended, then the capacitor assy must be removed to prevent fumes being produced during the welding opn. It should also be noted that due to the nature of this large capacitor assy., there exists a significant electrical hazard associated with this item. Time must be taken in discharging and disassembling this unit.	
	There are several testing procedures involved in the overhaul of this unit. It is also an involved process to disassemble and repair the capacitor assembly. Much of the testing equip. is outdated and prone to long down times, and in some cases modified testing must be performed due to inadequate or missing equipment.	
	Note that there are several cases where inspections and/or tests can indicate that further machining or welding must be performed as support work. The possibility therefor exists that significant time may be spent on any one item in backshop operations.	
5/8/69 PIO # 3	Suggestion that a detailed analysis be performed as to viability of new test equipment (generalized in nature) given decreasing demand of these items.	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/8/85 (5/7/85) PIO # 4	(continued) PN 49711A. Mr. Ware notes that new parts from the manufacturer are displaying a high failure rate, mainly due to improper packing from the manufacturer. Note: This item is the same as PCN 98001A, except for the gap tube assy. The new gap tube assy. in the 49711A uses Kr 85 as compared to the older 98001A model's Cs 137. This modification was to reduce radiation exposure to the employee.	MATPCA

ENGR NOTES

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
05/08/89	Interview with Donzida Stroud on PCN 30241A. As with most of the ignition exciters, this item requires an initial functional test. If the item tests OK, it is routed back into inventory. The failure rate of this item is reported as ~ 95%, so most items are overhauled. The exciter must be sent to the machine shop (MATPCM) for lid removal. Note that there is significant delay time (24 hrs) before the item is returned to MATPCA. This is due to several factors, especially the fact that normally only one (MATPCM machine and operator [illegible] assigned for this task. Also note that Ms. Stroud reports that 30% of the disassembled units are found to welding for terminal rework or casing repair. Another 24 hr delay is [illegible] by this operation. The unit is returned to MATPCA for further overhaul, and sent back to welding for lid replacement. It can be seen that there exists the possibility of a 48-72 hr delay above and beyond the specific time required for repair of the item. Time required for task: Time corded task: PIO # 5 Suggestion for study of back shop operations for all MATPCA support work. Target MATPCM and MATPIW for long delay times.	MATPCA

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
05/09/89	Interview with Wendel Hawkins on PCN 50078A. This is an ignition exciter which requires an initial function test be performed. It is reported that 90% of the items fail and are overhaulded. The other 10% are routed back into the inventory. This item is presently having an Air Force audit performed which requires computer tracking and extra paperwork. This is indicated in the operation profile sheet. The components of this item have a high damage potential when exposed to moisture, which requires that the unit be kept in MATPCA's dehumidifier (which is in actuality an unpowered refrigerator packed with dessicant), long drying times in both the oven and this dehumidifier are required. The unit must be sealed and pressurized so that moisture does not enter the casing. This in turn required a rather high degree of skilled soldering be performed around the casing and input leads. Care must be taken not to heat the casing overly much during this procedure, as internal components are heat sensitive. PIO # 6 Suggest the use of some form of epoxy sealant that would remove the soldering operation. This should save much time and effort by operator.	MATPCA

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
05/19/89	Interview with Mr. Wendel Hawkins, WG-10, on ignition exciter (355107A) This item has an initial functional test, the results of which determine rather it is overhauled or returned to inventory. It was reported that this item has a 50% failure rate.	MATPCA
	The testing of internal components in this item is a somewhat complex procedure. Several test stands are required, as well as individual handheld equipment such as ohmmeters and voltmeters.	
	Note that if the internal connectors need to be reworked the item must be sent to welding (MATPIW). Approximately 15% of all units require this additional operation. All disassembled units will have the lid removed by MATPCM and replaced by MATPIW. Possible back shop time is therefor 48-72 hours.	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/10/89	Interview with James Dye on PCN 38545A, TEMP. AMPLIFIER	MAT PCA

This is a very complex overhaul item. The temp. amplifier is a MATROC item, and only 40% fail the initial test and require overhaul. Of these, 95% of the failure involves a module failure. There are five modules, and each will require a different replacement time if it fails. Note especially the A3 module. If the A3 module fails, there is an ~9.0 hour repair time involved. This is due to the fact that this is a "select-fit" item, which requires individual testing and specifications determination before it can be installed. (See following PIO suggestion).

There is a great deal of rewiring and rerouting of wire, after a module change. RTV sealant must also be applied over these wires (which is very tedious to remove).

Functional testing is performed at three temperatures (Ambient, cold, HOT), with most failures occuring at the cold temperatures. A failure at any temperature will stop testing and require troubleshooting be performed. After repair or replacement of parts, testing must repeated.

PIO # 7 Suggest that manufacturer supply data of related parts for "select fit" items. In the case of A3 module, reduce time from 9.0 hrs to ~3.0 hours for change. (i.e. reduce need for determining existing specifications).

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/10/69	Interview with wallace wylie on PCN 38643A, Temp. Amplifier. This item is rather complex in both its testing and repair. The amplifier consists of five major internal components, any one of which may cause the item to fail. These internal components are modules numbered 1-5. The individual failure rates are listed on the operation profile sheet for opns. 151 - 153. This item is classified as a MATROC item, and requires an initial functional test be performed. 80% of all amplifiers of this type tested pass the test. They are then returned to inventory. The other twenty percent require disassembly and replacement of one or more modules. It should be noted that the amplifier interior is sealed with a potting compound which is very difficult to remove. Note that the amplifier fails mostly during the ambient temperature phase of testing.	MATRCA

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/16/89	Interview with Mr. Humphrey on PCN 61234A, ignition exciter.	MATRCA
	This item is not designated a MATROC item, but most technicians are performing an initial functional test as part of their troubleshooting procedure. This item is reported as having a 40% pass rate of these initial tests. This would seem to indicate that making this a "selectively overhauled" item is a viable option.	
	Note that there are several internal components in this exciter which can fail and each of these will take a different repair time. Also note that there is often the possibility of more than one internal component failing at any one time	
	It should be mentioned that this exciter's tube assemblys are installed in a formed rubber casing. This casing is easily removed and prevents arcing while installed	
	PIO # 8 Suggest that this exciter be designated as a MATROC item to take advantage of 40% pass rate. mention transformer inspection.	
	PIO # 9 Suggest that focus study be performed on all Exciters as well as many other electrical accessory items now using RTV or potting compound. Explore feasibility of using formed rubber housing (prevents arcing, protects from shock, seals, etc.).	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/16/89	Interview with Mr. Humphrey on PCN 50217A, ignition exciter. This item is basically identical to the ignition exciter PCN 61234A. Again no initial function test is required, although troubleshooting before overhaul indicates that 40% of all items tested are fully functional. The only real differences existing between the two aforementioned PCNs is that the 50217A as two capacitors in the capacitor #1 assy. as opposed to one in the 61234A. It should also be noted that instead of RTV being used as an internal insulator and sealer, a hardening compound is poured into the exciter during closeout. This forms a hard plastic cover which is time-consuming to remove. PIO #10 Suggest use of RTV sealer as in case of 61234A. Much easier to remove. PIO #11 Same as suggestion #8.	MAT PCA

DAILY ACTIVITY LOG

DATE/REC	SUBJECT/ACTIVITY	NEXT ACTION/ ASSIGNMENT
05/19/89	Interview on Solenoid ASSY (38694A). This item will have the the casing opened and a visual inspection performed. If all internal components are within wear limits, a functional test is performed. 20% of all items are judged fit to be returned to inventory. Turnaround time is two hours in these cases. 80% of these items require overhaul. If the armiture assembly must be removed, the item is sent to welding. Turnaround at MATPIW is estimated by the interviewee as 72.0 hours average. This is due to this item being designated as a low priority item.	MATPCA
	In rebuilding this item, an internal actuation device must be adjusted by placement of shims and washers. As this is an imprecise procedure, the possibility exists for multiple teardowns on each item. This was reported as rare.	
	Total time required for rebuild is 3.5 hours.	
	PIO # 12 Observation of improperly designed hand tools (power and manual). suggest use of ergonomical tool designs.	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
05/19/89	Interview with Wendel Hawkins on PCN # 97133A, Electromag 3-way select valve.	MAT PCA
	This item is rebuilt each time it enters the depot, and a rebuild kit is required for each item.	
	One port of the valve is closed off by the user organization due to this items modified use as an air bleed-off valve, Technical specifications still in effect require that the valve be tested on the fuel transfer equipment located in bld. 3108, This test utilizes the third port normally plugged while in use on aircraft engines, and would appear unnecessary.	
	It should also be noted that there is no specific requirement to leak test the valve with compressed air before taking the item to the test equipment in 3108. If the item leaks with compressed air being applied, then the test using the fuel transfer station could not be performed.	
	PIO # 13 Suggest the test requirement for fuel transfer procedure be deleted from tech. data.	
	PIO # 14 Suggest that testing of the valve with compressed air before being sent to fuel transfer station in bld. 3108 (if above PIO not acceptable).	

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/19/89	Interview with Wendel Hawkins on PCN # 34551A, Solenoid Valve.	MAT PCA
	This item is 100% overhaul. Operations 115 to 170 of the WCD (CAEZ04) are performed in building 3108 by personnel assigned to the fuel testing facility.	
	A rebuild kit is required for each solenoid valve that is overhauled.	
	Total time for rebuild, including a 12.0 hour mandatory flow time in bld. 3108, 14.6 hours.	

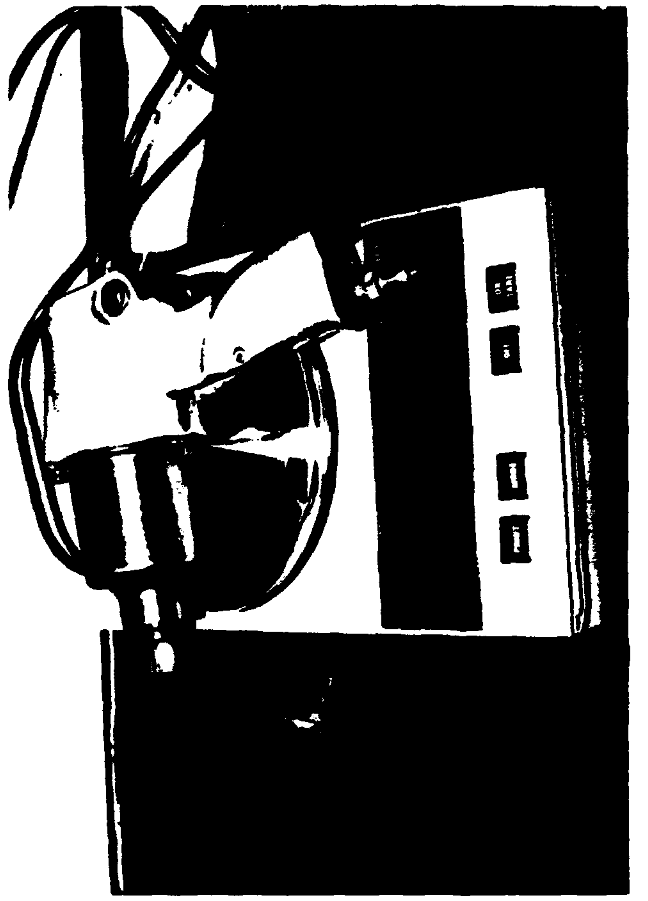
DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/19/89	Interview with Richard Franklin about Automatic Ignition Actuator, PCN 35111A.	MATPCA
	This is a 100% overhaul item. It requires a disassembly and visual inspection as well as electrical testing.	
	Note that there is a requirement to electrically test the activation switch in the cover & switch assembly. Under present conditions, if the switch tests bad, the entire cover housing must be replaced. The switch is set into the housing with a special potting compound, which must be purchased from BENDIX Corporation. Bendix also manufactures the cover housing. Technicians report that they are unable to obtain the potting compound, and must replace the entire housing assembly as a unit. The cost of a new housing assembly is $800.00, which makes the reluctance of Bendix in providing the potting compound as highly suspect.	
	PIO # 18 Suggest that Bendix be encouraged to sell both the potting compound and small switch assy. to user organization. This cover housing assy. should be a repairable item.	

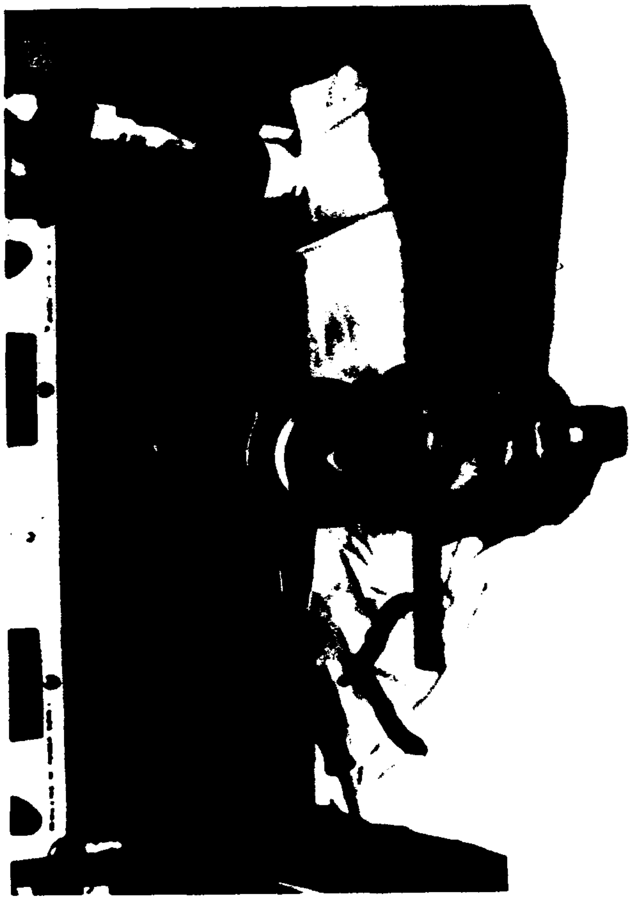
DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/19/89	Interview with LARRY Ware on ignition exciter PCN 50297A.	MATPCA
	This is a MATROC item which requires an initial functional test. Five percent of all items tested fail and must be overhauled. The rest are returned to inventory.	
	Note that there is are 24.0 hour delays at both the machining (MATPCM) and welding (MATPIW) backshop operations.	
	This item must be sandblasted and painted after overhauled. A rebuild kit is required for each overhauled item.	
	PIO #15 Humidity control chamber required in MATPCA area. Presently using an old refrigerator packed with decsicant.	

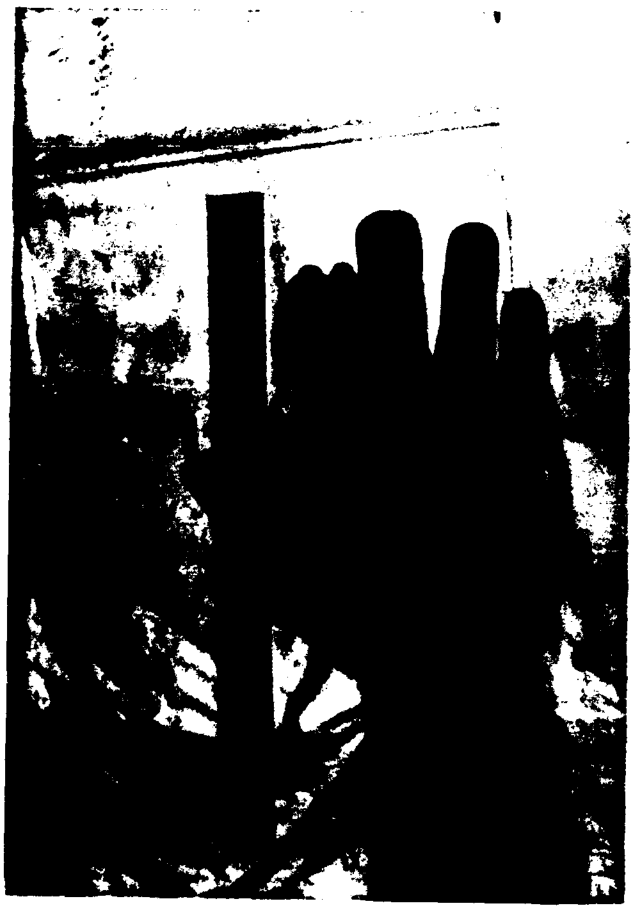
DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/19/89	Interview with Richard Franklin on PCN 35113A, control relay box.	MAT PCA
	This item is a MATPAC designation, but pass rate is only about 5%. Note that a major internal component is the amplifier assembly. This component is produced in ENGLAND at a purchase price of $2,700.00. The component is often repairable at a cost of $100 or less. No repair time is allowed for these components.	
	PIO # 16 The amplifier assy. for the control relay box PCN 35113A should be made a repairable item and have a standard repair time assigned to it. Average savings per component: $2600.00	
	PIO # 17 Focus study should be performed to specifically identify all repairable parts, and a detailed cost analysis made to compare costs of repair vs. replacement of individual components.	

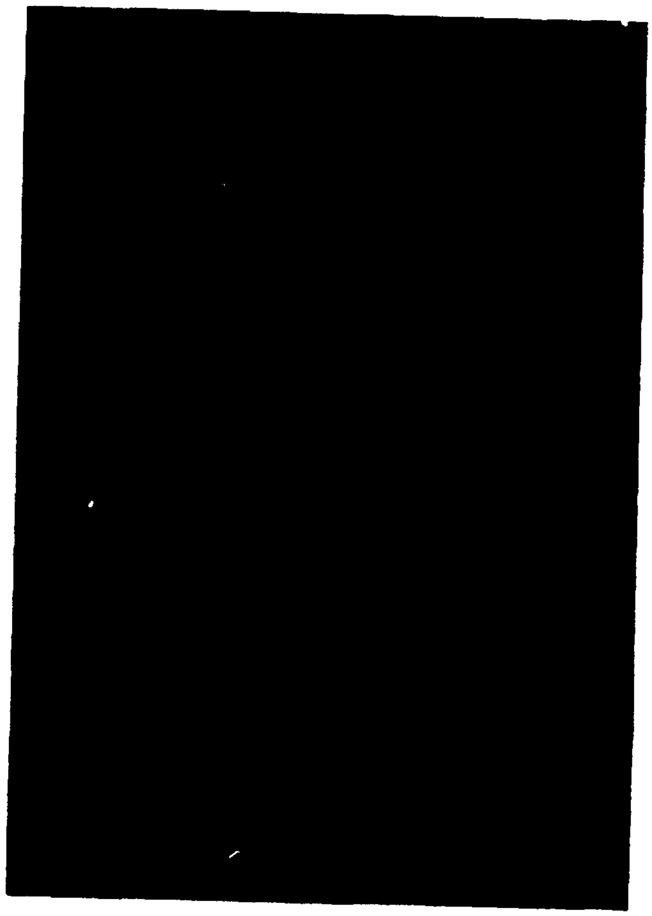
DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/22/85	Interview with Donelda Stroud on ACN 35033A, Liquid Level Sensor. This is an inspectable item which may be returned to inventory if it passes both a visual and electrical inspection. The sensor is partially disassembled and the terminal boards are inspected for cracks, etc. If no obvious defect exists, an electrical test is performed using a multimeter. If this test is OK, the item is reassembled and return to inventory. ~20% of all sensors fail either the visual or electrical inspections. Of these, approximately 15% of all those require replacement of the terminal board itself. These are then retested and reassembled if now functional.	MATPCA

DATE/PIO #	PIO SUBJECT AND SUPPORTING DATA	RCC
5/25/89	Interview with Franklin Martin on PCN 34252A, Flowmeter PWR. supply.	MATPCA
	This PWR Supply is a MATROC designated item. Technicians report that only 5% of the tested items are functional, the rest requiring overhaul.	
	Note that the internal circuit board of this item is repairable. The technicians will do this repair in their spare time, when possible, but are not assigned a primary responsibility in this. Again, they are not given a standard time to work these and any repair is therefore left to the initiative of the employee. Cost of replacement: [illegible] Cost of repair: unknown at this time	
	Note: This item is the same as PCN 34253A in all respects except the housings. All internal components are interchangeable.	
	PIO # 19 Suggest a focus study be performed of cost-benefit of repairing the internal circuit boards mentioned above. Should include cost analysis of repair vs. replace, economic order quantity of parts, etc.	









CAEZ03 * WORK CONTROL DOCUMENT * JC   1.DATE 88203   PAGE 1 OF 3 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
		MTFCAP	89094	

7.PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
6069170		2J-TF41-13-7, WP 007 00 8/16/H CHG 20

10.MODEL/DESIGN/SERIES | 11.STOCK NR
TF41-A1/402D

13.MISC | 14.NOUN/END ITEM NOUN
GEARBOX ASSEMBLY   PACI
WOLF ROM/MATEAC/65920

15.DISP 16.PDN/

STATION	OP NR	17.WORK TO BE ACCOMPLISHED	18.MECH		20
		30056A 2840001/27202CN TF41-A1			
		61176A 2840001/27202GL TF41 A2			
		F 2840 00 232 7643CN TF41-A2			
W 40	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLLERANCES REQUIRING COMPLIANCE.	M		
	030	refurb DISASSEMBLE. Test, sw replace	M		
	040	CLEAN AS REQUIRED. Transit [illegible]	M		
	050	INSPECT. Visual	M		
	060	INSPECT SHUTOFF VALVE DRIVING ARM FOR SPLINE WEAR. ACT_______________INCH	M IC		
	070	INSPECT MANUAL FUEL CONTROL DRIVING ARM FOR SPLINE WEAR. ACT_______________INCH	M		
	080	INSPECT MAIN FUEL CONTROL DRIVING ARM FOR SPLINE WEAR. ACT_______________INCH	M		
	090	INSPECT DRIVING SHAFT GEAR FOR ACT_______________INCH *SPANNER WRENCH NO 6798371	M		
	100	INSPECT SHUTOFF VALVE DRIVING GEAR SHAFT, SPLINE WEAR . ACT_______________INCH	M		

[illegible] replace [illegible] clean [illegible] serviceable

15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	110	INSPECT DRIVE SHAFT, SPLINE WEAR . ACT_______________INCH	M		
	120	LUBRICATE AS REQUIRED.	M		
	130	REASSEMBLE.	M		
	140	TIGHTEN SPANNER NUT (14) *SPANNER WRENCH NO. 6770371 ACT_______________IN/LBS	M		
	150	ADJUST STOP UNTIL GAGE IS IN CONTACT WITH BOTH STOP & CONTROL ARM. ACT_______________INCH	M		
	155	REMOVE THE INDEXING PIN AND ROTATE CAMBOX LEVER TOWARD INTERMEDIATE. CONTINUE UNTIL SWITCH ACTUATES AND LIGHT COMES ON. ACT___________________DEG. *GAGE, SETTING CAMBOX LOCKOUT SWITCH	M		
	158	HORIZONTALLY ALIGN SWITCH ROLLER TO SURFACE. TIGHTEN THE TWO SWITCH LOCKNUTS & LOCKWIRE TO EACH OTHER. ACT:__________________IN/LB *TORQUE WRENCH	M		
	160	TEST: ROTATE CAMBOX INPUT SHAFT CLOCKWISE UNTIL A 0.1875 TO 0.1880 IN. DIA. RIGGING PIN CAN BE INSERTED THROUGH THE INDEX HOLE MARKED IDLE. MEASURE THE ANGULAR TRAVEL OF CAMBOX ACT___________________DEG.			
	170	ROTATE CAMBOX INPUT SHAFT CLOCKWISE UNTIL 0.1875 TO .1880 RIGGING PIN CAN BE INSERTED IN HOLE MARKED INT. MEASURE TOTAL ANGULAR TRAVEL OF CAMBOX INPUT LEVER. ACT______________DEG.	M		
	220	CHECK BACKLASH "B" OF THE CAMBOX HP FUEL SHUTOFF VALVE OUTPUT LEVER AT POINT "C". ACT:_______________INCH	M		
	230	THE TORQUE REQUIRED TO MOVE THE CAM- BOX INPUT FROM THE OFF TO IDLE RANGE ACT:_______________IN/LB	M		

(CONTINUED)

CAL203 * WORK CONTROL DOCUMENT * JC 1.DATE 80203 PAGE 3 OF 3 PAGES
15.DIST 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		*TORQUE WRENCH			
	260	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	270	SAFETYWIRE.	M		
	[illegible]	OPERATIONS COMPLETED & PAPERWORK PROCESSED.	M		
	[illegible]	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., [illegible], CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M		
	[illegible]	COMPLY WITH MACI 66-30, [illegible] TYPE WORK PERFORMED________________	M		

| CAEB05 * WORK CONTROL DOCUMENT * JC   1.DATE 89033   PAGE 1 OF 2 PAGES |

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
		MIPCAJ	89094	

7. PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
		10 AA1-2 ... 8L1 2 16 13 062741I CHG 15

10.MODEL/DESIGN/SERIES | 11.STOCK NR

J57 43/59

13.MISC | 14.NOUN/END ITEM NOUN
IGNITION EXCITER   PAC
...MAIL AC/65920

DONELDA STROUD
KATY WILSON

NSN   C/N
2925000348118RU 30241A
2925011711813RU ...01A

STATION	OP NR	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
W 43	010	RECEIVE, IDENTIFY AND ATTACH PAPER WORK.	M		
	020	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
Test		QC# (initial) 4929			
	030	INSPECT & CLEAN.	M		
0 57	040	MOVE TO MACHINE SHOP MATICM FOR REMOVAL OF COVER.	M		
	040	DISASSEMBLE.	M		
Test					
	050	MIPIW WELD FILTER AND OUTPUT TERMINALS. REQ.__________NOT REQ.__________	M		
	310	REPAIR OR REPLACE AS NECESSARY.	M		
QC 4929	320	REASSEMBLE.	M		
test		QC: 4020 + 3953			
	360	MIPIW MOVE TO WELDING SHOP MIPIW FOR FUSE ARC WELD COVER WITH FILLER ROD OX-WELD NO. 65 AND ACCOMPLISH LEAK TEST	M		
	365	PAINT REQ__________ NOT REQ__________	M		
	370	~~BAKE FOR TWO HOURS AT 190 DEG F TO~~ 225 DEG F.	M		2.5 hr

| CAE005 * WORK CONTROL DOCUMENT * 30 1.DATE 07033 PAGE 2 OF 2 PAGES |

15.DISP STATION	16.PDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19 [illegible]	20.[illegible]
	380	TEST: HERMETIC SEALING AND LEAKAGE. 2W/2	M		
	440	PRESSURIZE EXCITER TO 15 PSIG WITH DRYAIR HAVING A DEW POINT OF 65 DEG F.	M 1 min		
	450	LEAKAGE TEST: IMMERSE EXCITER IN WATER 180 TO 200 DEG F FOR ONE MINUTE. NO LEAKAGE ALLOWED.	M 3		
	460	ELECTRICAL TEST.	1 [illegible] M 4 ← 1 [illegible]		
	470	AFTO FORM 349 COMPLETED AND FORWARDED TO DATA AUTOMATION.	M 5 min		
	500	SAFETYWIRE	M 15 min		
	510	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., ITS CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M 2 min		
	520	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M 5 min		
	530	COMPLY WITH MASI 66 66, PARA [illegible]. TYPE WORK PERFORMED________________	M 1 min		

CALC04 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89040 PAGE 1 OF 3 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
34044A		MTFCAP	89074	

7. PART NUMBER 41469/42590 (M)

9. ITEM SERIAL NR

10/12. TECH DATA/OPTIONAL +98093
PO MAT87-16
PO MAT87-3
8E1 8 8-3 87/7/4H
CHG 21
8E1 8-8-3-1 8000 H
CHG 3

10. MODEL/DESIGN/SERIES: TF33 P7

11. STOCK NR 2925009862055RV

13. MISC / 14. NOUN/END ITEM NOUN: IGNITION EXCITER — FAC
JENNINGS/MATLAC/65920

JOHN GEISSLER

STATION/OP NO.		17. WORK TO BE ACCOMPLISHED	18.	19.	20.
		20% TOTAL TEARDOWN			
W-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE.	M	120	
	030	CLEAN AS REQUIRED.	M	6	
	040	INSPECT. (VISUAL)	M	6	
	060	TEST CAPACITORS IAW T.O. FLASH 20' METER 40' ~~(REPLACE~~ EPOXY ~~[illegible]~~) ~~OR WELD~~ 2 CAP	OC 4929 M	.12	35% R 4929
	070	TEST FILTER IAW T.O. TEST STAND 1 FILTER TEST INDUCTORS (2) 3 MIN 10% REPL	M	6	15% R
	080	TEST RESISTORS IAW T.O. (4) EA	M	6	5% R
	090	TEST DISCHARGER TUBE #24498 AND 24222 IAW T.O. (3) EA (TEST 20')	M	12	60% R
	100	TEST FEED-THROUGH TERMINAL IAW T.O. (1) EA TEST STAND	M	6	5% R
	110	TEST PWR TRANSF. IAW T.O.	M	6	5% R
	120	TEST VIBRATOR IAW T.O.	M	6	UPDAT 100% MOD
	380	REPAIR OR REPLACE AS NECESSARY.	M	~~12~~	

.42 DEC HR

15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"T"	20"Q"	
	390	REASSEMBLE. & TORQUE AS REQ'D	M	180 ~~3.0~~		
DELETE	~~440~~	~~TORQUE ALL INSIDE SCREWS & NUTS AND~~ ~~CAP (13) IAW T.O.~~	M			
	460	INTERMEDIATE TEST: APPLY 14 V FOR 10 SECONDS MAX. OBTAIN 3100 3400V. ACT:____________________V INPUT VOLTAGE 14 24 29 SPARKS OVER 10 SEC 3.0 3.0 3.0 PERIOD (MINIMUM) ACTUAL ____ ____ ____ AMPS (MAXIMUM) 5.0 5.0 5.0 ACTUAL ____ ____ ____ CONTINUOUS DUTY CIRCUIT TEST: STOR- AGE CAPACITOR VOLTAGE ACTUAL_________VOLTS INPUT CURRENT ACTUAL_________AMP SPARK RATE, LEFT HAND OUTPUT, 10-20 SPARKS IN 10 SECONDS. TRIGGERING CIRCUITS TEST: APPLY 24 VDC FOR 10 SECONDS. CONSISTENT SPARKING MUST BE OBSERVED IN WINDOWS OF BOTH TESTER. INSERT SHORTING CAP TO ONE TESTER AT A TIME. MUST WORK CORRECTLY. TESTER #1: GAP 0.200, 25 PSIG. TESTER #2: GAP 0.100, 5 PSIG. OBTAIN GAP 0.200 INCH, 20 PSIG. "C" PIN 115 V 400 CYCLE. CONSISTENT SPARKING.	M	~~6~~ 9		TEST STA[illegible] OC 4929
	520	FILL WITH POTTING COMPOUND AND BAKE IAW T.O. FLOW 180MIN	M 6			
	525	TORQUE ALL SCREWS OR NUTS OUTSIDE OF CASE. IAW T.O. (SOLDER SEAL CASE)	M 18			
	530	TEST FOR LEAKS: APPLY 15 PSIG. LEAK- AGE 1 X 10 -6 CUBIC CENTIMETERS PER SECOND MAXIMUM. (ALT LEAK CHECK IN WATER) ACTUAL________________	M 6		OC 3952	
	540	PRESSURE GAS CHARGE EXCITER. 30 FLOW OVEN	M 6			24[illegible] OC
	560	PAINT 240 FLOW	SNAG M 18			?
	570	FINAL TESTING OUTPUT ENERGY LEVEL AND SPARK	M 9	OC (SEE	4929 460)	

(CONTINUED)

WORK CONTROL DOCUMENT [illegible] 1. DATE [illegible] PAGE [illegible]

15. STATION	16. OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19	20
		RATE OF INTERMITTENT DUTY CIRCUIT. APPLY 24 V INPUT CURRENT 5.0 AMPS MAXIMUM. STORED ENERGY ACTUAL__________METER READING SPARK RATE ACTUAL___________ OUTPUT ENERGY LEVEL OF CONTINUOUS DUTY CIRCUIT. APPLY 115 V 400 CYCLE INPUT CURRENT 2.5 AMPS RMS. STORED ENERGY ACTUAL__________METER READING SPARK RATE ACTUAL___________ TRIGGERING CIRCUITS IN INTERMITTENT DUTY CIRCUIT GAP 0.100 IN & 5 PSIG. APPLY 24 VDC FOR 10 SEC MINIMUM. CONSISTENT SPARKING. INSERT SHORTING CAP TO EACH OUTPUT TERMINAL IN TURN. MUST FIRE CONSISTENTLY. TESTER #1: GAP 0.200, 25 PSIG TESTER #2: GAP 0.100, 5 PSIG. MUST FIRE CONSISTENTLY. REVERSE AND TEST. OBTAIN GAP 0.200 INCH, 25 PSIG. APPLY PIN "D" 115 V 400 CYCLE. OBSERVE CONSISTENT SPARKING.			
	650	SAFETY WIRE	M 3		
	660	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M 3		
	670	OPERATIONS COMPLETED & PAPERWORK PROCESSED. AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M 6		
	680	COMPLY WITH MAOI 66-36 PARA 13 TYPE WORK PERFORMED ______________ 12 HRS LEAK TEST BRNCH / ENDERSON	M 3		

[illegible] - WORK CONTROL DOCUMENT [illegible] | DATE [illegible] | PAGE [illegible] PAGES

12. ORIG/PROD NR	13. QUANTITY	14. PROD SECTION/RCC	15. DATE [illegible]	16. DATE [illegible]
[illegible]		[illegible]	[illegible]	

PART NUMBER	19. ITEM SERIAL NR	18/12. TECH DATA/OPTIONS
[illegible]		[illegible]

[illegible] MODEL/DESIGN/SER [illegible] STOCK NR | [illegible]

[illegible] | [illegible]

[illegible] NOUN/LND ITEM NOUN

[illegible]

[illegible]

OPERATION NO	17. WORK TO BE ACCOMPLISHED	[illegible]		
010 [illegible]	REC. ID, IDENTIFY & ATTACH PAPERWORK.	M		
015	ALL REFERENCES ARE TO THE [illegible] AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE	M		
020	DISASSEMBLE AS REQUIRED.	M		
030	CLEAN AS REQUIRED.	M		
040	INSPECT, STRAIGHTEN IF NECESSARY	M		
045	FLUORESCENT PENETRANT INSPECTION [illegible] ROUTE TO [illegible]	M		
050 [illegible]	WORK COMPLETE, ROUTE TO [illegible]	M		
060 ATPCA	REPAIR & REPLACE AS NECESSARY	M		
070	REASSEMBLE IAW [illegible] NOTE: BAKE PROBES PRIOR TO RESISTANCE CHECK IAW NOTE PARA. 4-5A.	M		
080	CHECK RESISTANCE (WHEATSTONE BRIDGE) ACT QHA3	M		
090	CHECK INSULATION RESISTANCE (MEGGER) ACT QHA3	M		
100	HEATER PROBE TEST [illegible] (JETCAL ANALYZER) ACT SPREAD. ENTER ACTUAL TEMPERATURE VALUE FROM	M		

(CONTINUED)

CAFY08 * WORK CONTROL DOCUMENT * [illegible]		DATE 88307 PAGE 2 OF 2 PAGES			
15. DISP-16. PDN/					
STA	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19. [illegible]	20. [illegible]
		STEP 100 ABOVE ON REVERSE OF SERVICEABLE TAG, DD 1574.			
	110	SAFETY WIRE.	M		
	120	COMPLETE & FORWARD [illegible] TO DATA PROCESSING	M		
	125	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW [illegible] CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROGRAM ORDERS.	M		
	130	OPERATIONS COMPLETE, PAPERWORK PROCESSED	M		
	140	COMPLY WITH [illegible] PARA [illegible] TYPE WORK PERFORMED	M		

CAAC02 * WORK CONTROL DOCUMENT * JC   1.DATE 89010   PAGE 1 OF 1 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
34252A		MIFCA	89139	

7.PART NUMBER: 8TJ510AA4
9.ITEM SERIAL NR:
8/12.TECH DATA/OPTIONAL: 5L14-2-7-13   34274H
CHG 13

May 22, 1989

10.MODEL/DESIGN/SERIES: B52
11.STOCK NR: 6130007728566NT

Mr. Martin Franklin,
+ this is the same quantity
process as - DCN #34253A.

13.MISC
14.NOUN/END ITEM NOUN: FLOWMETER PWR SUPPLY   PAC
YEARY/MATEAA/65920

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"F"	20"G"
		ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.			
W-41	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	050	DISASSEMBLE	M		
	060	CLEAN	M		
	070	INSPECT	M		
	100	LUBRICATE AS REQUIRED	M		
	110	REASSEMBLE	M		
	115	TEST.	M		
	120	COMPLY WITH MAUI 66-36, PARA 13 TYPE WORK PERFORMED OVERHAULED	M		
	170	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	This mechanic M stamp WCD-sheet. 1 mem. 6.027		
	180	OPERATIONS COMPLETE AND PAPERWORK PROCESSED.	M		

[illegible] * WORK CONTROL DOCUMENT * JC   1.DATE [illegible] PAGE 1 OF 1 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
[illegible]		MITCA	[illegible]	

7.PART NUMBER	9.ITEM SERIAL NR	10/12.TECH DATA/OPTIONAL
[illegible]		SL14 2 / 13 CHG 13

8.MODEL/DESIGN/SERIES	11.STOCK NR
[illegible]	[illegible]/NT

13.[illegible] 14.NOUN/END ITEM NOUN
FUEL FLOWMETER PWR SUPPLY PAC
YEARY/MATLAA/65920

15.DIST STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
		ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.			
W 41	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	DISASSEMBLE.	M		
	030	CLEAN.	M		
	040	INSPECT.	M		
	050	LUBRICATE AS REQUIRED.	M		

	060	REASSEMBLE.	M			
	080	COMPLY WITH MA01 66 33, PARA 13. TYPE WORK PERFORMED________________	M			
	090	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M			
	100	OPERATIONS COMPLETE AND [illegible] PROCESSED.	M			

GAA024 * WORK CONTROL DOCUMENT * JC 1.DATE 07010 PAGE 1 OF 1 PAGES

2.ORIG/PROD NR: 34253A | 3.QUANTITY: | 4.PROD SECTION/RCC: MIPCA | 5.DATE SCHED: 07134 | 6.DATE COMP:

7.PART NUMBER: 6TJ516AA5 | 9.ITEM SERIAL NR: | 8/12.TECH DATA/OPTIONAL: 5L14-2-7-13 CHG 13 042/4H

10.MODEL/DESIGN/SERIES: 882 | 11.STOCK NR: 6130007720 56/NT

13.MISC | 14.NOUN/END ITEM NOUN: FUEL FLOWMETER PWR SUPPLY PAC -YEAR/MATEAA/65920

15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
		ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.			
W-41	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	DISASSEMBLE.	M		
	030	CLEAN.	M		
	040	INSPECT.	M		
	050	LUBRICATE AS REQUIRED.	M		
	060	REASSEMBLE.	M		

* CAEZ04 * WORK CONTROL DOCUMENT * JC   1.DATE 89161   PAGE 1 OF 2 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
34551A		MTFCAF MATRA	89055	

7. PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
		PO MAT07-3
		6J15-2-155-3 862440
10.MODEL/DESIGN/SERIES	11.STOCK NR	CHG 3
J141 A1/A2		Wendo /

13.MISC | 14.NOUN/END ITEM NOUN

SOLENOID VALVE   PAC

WOLFFRUM/MATLAC/65920

P/N	NSN	C/N
6867277	2915001776977UN	343974
6067277	2915001776977UE	61177A
6662255	4810001114113CN	34551A

15.DISP STATION	16.PBR/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"I"	20"Q"
W-41	010	RECEIVE, IDENTIFY AND ATTACH PAPERWORK.	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE.	M		
	030	CLEAN.	M		
	040	INSPECT.	M		
	~~050~~	APPLY 500 VDC FOR 5 SECONDS BETWEEN EACH PIN AND BODY. . ACT: MEGOHMS. MEGGER	M		
	060	CHECK CONTINUITY PINS (1-2) AND (3-4). PINS (1-2) ACT: OHMS PINS (3-4) ACT: OHMS .	M		
	080	CHECK AIR GAP IAW T.O. . ACT: INCH . .	M		S

CAEZ04 * WORK CONTROL DOCUMENT * JC		1.DATE 00161 PAGE 2 OF 2 PAGES			
15.DISP-	16.FUN/				
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	090	REPAIR OR REPLACE AS NECESSARY.	M		
	100	REASSEMBLE.	M		
	110	TORQUE SCREWS (12). ACT: LB IN *TORQUE WRENCH	M		
3105 ? Routing Symbol	115	PERFORM LOW PRESSURE FLOW LEAKAGE TEST: AT 330 PSIG. NO LEAKAGE ALLOWED OVER A PERIOD OF 2 MINUTES. *TEST SET.	M		
	130	PERFORM VALVE LEAKAGE TEST AT 1800 PSIG FOR 2 MINUTES. NO LEAKAGE ALLOWED. **TEST STAND**	M		
	140	CALIBRATION: CHECK FLOW THROUGH VALVE. ACT: LB/HR	M	Done in 3108	
	150	CHECK LEAKAGE FROM OUTLET CONNECTION. . ACT: CC/MIN	M		
	160	APPLY 1930 PSIG INLET PRESSURE. NO LEAKAGE EXCEPT FROM OUTLET CONNECTION.	M		
	170	APPLY 130 PSIG. NO LEAKAGE ALLOWED OVER 2 MINUTE PERIOD.	M		
W-43	175	~~PAINT~~ REQ NOT REQ Del	M		
	178	[redacted] ELECTRICAL CHECK APPLY 500 VDC [redacted] SECONDS BETWEEN EACH PIN AND [redacted]Y. ACT: MEGOHMS.	M		
	180	AFTO FORM 349 COMPLETED AND FORWARDED TO DATA AUTOMATION.	M		
	235	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M Smith		
	240	OPERATIONS COMPLETE AND PAPER-WORK PROCESSED.	M		
	255	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED	M		

CACY10 * WORK CONTROL DOCUMENT * JC   1.DATE 8830? PAGE 1 OF 5 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
35023A		MTPCA	89094	

7. PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
42127 (M)		PO MAT88-3 8E1-8-12-3 872008 CHG 8

10.MODEL/DESIGN/SERIES	11.STOCK NR
TF30 P103,107,1 -09	2925009413708PQ

13.MISC | 14.NOUN/END ITEM NOUN
IGNITION EXCITER   PACI   JOHN
TOMPKINS/MATEAC/65920

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"I"	20"Q"
W 41	010	RECEIVE, IDENTIFY & ATCH PAPERWORK.	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLLERANCES REQUIRING COMPLIANCE.	M		
	020	PRELIMINARY CHECK: MEASURE RESIST ANCE BETWEEN OUTPUT TERMINAL AND GROUND *VIVM* ACT:______________OHMS.	M		
COMPOUND	030	TEST: OUTPUT ENERGY LEVEL & SPARK RATE: . SIX MIN OP R ACT:___________________AMP OBTAIN STORED ENERGY . *EXCITER TESTER* ACT:_____________METER READING	M		
	040	APPLY 21.0 VOLTS/RMS. OBTAIN 1.0 SPARKS PER SECOND MINIMUM.	M		
	050	TEST TRIGGERING CIRCUIT: ADJUST FOR CAP & INTERNAL PRESSURE. . ACT__________INCH ACT___________PSIG APPLY 21.0 VOLTS/RMS 400 CYCLE. OBTAIN CONSISTANT SPARKING.	M		
	060	PRESSURE TEST: SUBMERGE IN WATER 180 DEG F MIN FOR 1 MINUTE. NO LEAKS .	M		
	070	DISASSEMBLE.	M		

CAEY10 * WORK CONTROL DOCUMENT * JC 1.DATE 8830/ PAGE 2 OF 5 PAGES

15.DISP 16.FDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	080	REMOVE COVERS.	M		
	090	CLEAN AS REQUIRED.	M		
	100	INSPECT.	M		
0-30	110 MTPIW	WELD INPUT & OUTPUT TERMINALS REQ:____________NOT REQ:____________	M		
	130	FLASH TEST CAPACITOR: IAW T.O. . . "C" "D" & CASE ACT:____________SEC ACT____________MA. "A" & "B" ACT:____________SEC ACT:____________MA. "A" "B" & CASE ACT:____________SEC ACT:____________MA.	M		
	140	CHECK CAPACITANCE: "A" TO "B" ACT:_______________UF "B" TO "C" ACT:_______________UF "C" TO CASE - ACT:_______________UF "D" TO CASE ACT:_______________UF "B" TO CASE - ACT:_______________UF *CAPACITOR BRIDGE TESTER*	M		
	150	FILTER TEST: IAW T.O. ACT:______________OHM	M		
	160	APPLY 500 VOLTS DC BETWEEN PINS OF INPUT RECEPTACLE FOR ONE MINUTE MIN	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		IMUM. NO BREAKDOWN ALLOWED.			
	170	CHECK LEAKAGE BETWEEN "B" & GROUND FOR ONE MINUTE. . *VTVM* ACT:___________MEGOHM.	M		
	180	MEASURE RESISTOR'S (2) . NO. 1 ACT:_____________OHMS NO. 2. ACT:_____________OHMS *VTVM*	M		
	190	RECTIFIER TUBE TEST: APPLY 3000 VOLT INVERSE CURRENT AFTER APPROX 30 SEC. OBTAIN. #1 ACT:__________________SEC ACT:__________________MA #2 ACT:__________________SEC ACT:__________________MA #3 ACT:__________________SEC ACT:__________________MA #4 ACT:__________________SEC ACT:__________________MA *TEST CONSOLE*	M		
	200	OBTAIN 10 MILLIAMPERES FLOW. VOLTAGE DROP. #1 ACT:_______________VOLTS #2 ACT:_______________VOLTS #3 ACT:_______________VOLTS #4 ACT:_______________VOLTS	M		
	210	ESS POSITION - OBTAIN BREAKDOWN. STABILIZED STRIKING VOLTAGE . #1 ACT:__________________VOLTS	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		#2 ACT:________________VOLTS #3 ACT:________________VOLTS #4 ACT:________________VOLTS			
	220	DISCHARGER TUBE TEST: IAW T.O. ACT:____________________ *TEST CONSOLE, VOLTASCOPE, DISCHARGER TUBE TESTER*	M		
	230	HIGH TENSION INSULATOR TEST:IAW T.O.	M		
	240	POWER TRANSFORMER TEST: IAW T.O.	M		
	250	MEASURE RESISTANCE BETWEEN TWO SECONDARY LEADS. ACT___________OHMS ACT__________OHMS	M		
	260	APPLY 1.5 VOLTS BETWEEN PRIMARY INPUT LEAD & GROUND. EXCITER CURRENT . ACT:_____________AMP	M		
	270	CHECK VOLTASCOPE WAVEFORM FOR "HASH" AT 2500 VOLTS PEAK ON SECONDARY.	M		
	280	HIGH TENSION TRANSFORMER TEST: CHECK CONTINUITY.	M		
	290	ADJUST GAP & AN INTERNAL PRESS. ACT:_________________INCH ACT:_________________PSIG ACT:_________________VOLTS	M		
	300	REPAIR OR REPLACE AS NECESSARY.	M		
	310	REASSEMBLE.	M		
	320	INTERMEDIATE TEST ON OPEN EXCITER: APPLY INPUT VOLTAGE OF 21.0 VOLTS (RMS). OBTAIN 1.0 SPARKS PER SECOND MINIMUM ACT:______________	M		

(CONTINUED)

CAEY10 * WORK CONTROL DOCUMENT * JC 1.DATE 88307 PAGE 5 OF 5 PAGES

15.DISP STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		OBTAIN INPUT CURRENT . ACT:__________________AMPS OBTAIN STORAGE CAPACITOR VOLTAGE . ACT:______________VOLTS *OUTPUT TESTER EXCITER TESTER VOLTASCOPE*			
	330	TEST TRIGGERING CIRCUIT: IAW T.O. .	M		
0-35	340 MTPIW	WELD COVERS IAW T.O. .	M		
0-35	350 MTPIW	PRESSURE TEST: IAW T.O.	M		
	360	GAS CHARGING: BAKE EXCITER 30 MIN UTES. FILL DRY NITROGEN 10 POUND GAUGE. SOLDER TUBE.	M		
	380	BAKE 400 DEG. F. FOR 25 MINUTES.	M		
	390	TEST EXCITER: IAW T.O. . ACT:___________AMP . OBTAIN STORED ENERGY . ACT:________________METER READING	M		
	400	APPLY 21.0 VOLTS (RMS). OBTAIN 1.0 SPARKS PER SECOND MINIMUM. ACT:____________	M		
	410	TRIGGERING CIRCUIT TEST: IAW T.O.	M		
	420	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	460	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M		
	470	OPERATIONS COMPLETED & PAPERWORK PROCESSED.	M		
	475	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED_________________	M		

CAEY11 * WORK CONTROL DOCUMENT * JC   1.DATE 88307   PAGE 1 OF 2 PAGES

2.JOB NO/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
35033A		MTFCA	89093	

7.PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
0125154 (M)		PO MAT08-3
		7J14-3-3 051658

10.MODEL/DESIGN/SERIES 11.STOCK NR | CHG 5

1-30-103-107-10 | 6680001102660FW

13.MDS 14.NOUN/END ITEM NOUN

LIQUID LEVEL SENSOR PAC

MARKINGS/MATLAC/65920

15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"I"	20"B"
		F 6680-00-949-8272FB MET92A 350331 35033C			
9-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE AS REQUIRED.	M		
	030	CLEAN AS REQUIRED.	M		
	040	INSPECT.	M		
	050	MEASURE INSULATION RESISTANCE BE-TWEEN ALL FEED THRU LEADS AND CASE GROUND #1 ACT: MEGOHMS #2 ACT: MEGOHMS #3 ACT: MEGOHMS #4 ACT: MEGOHMS ACT: MEGOHMS #6 ACT: MEGOHMS *MULTIMETER	M		
	070	REPAIR OR REPLACE AS NECESSARY. (REPAIR IS LIMITED TO FOUR ITEMS AS PER T.O.)	M		
	080	REASSEMBLE. c/. seok	M		
	090	SAFETY WIRE OR SEALING COMPOUND THAT CONFORMS TO MIL-S-22473D WILL BE USED TO SECURE TERMINAL BLOCK SCREWS (5).	M		

CAEY11 * WORK CONTROL DOCUMENT * JC 1.DATE 8030/ PAGE 2 OF 2 PAGES

15.DISP STATION	16.FDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"?"	20"?"
	110	CONTINUITY AND RESISTANCE CHECK:	M		
		4 TO 2 ACT:			
		6 TO 2 ACT:			
		DIFFERENCE ACT:			
		4 TO 5 ACT:			
		6 TO 5 ACT:			
		DIFFERENCE ACT:			
		4 TO 1 ACT:			
		6 TO 1 ACT:			
		DIFFERENCE ACT:			
		4 TO 3 ACT:			
		6 TO 3 ACT:			
		DIFFERENCE ACT:			
	120	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	140	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M		
	150	OPERATIONS COMPLETED & PAPERWORK PROCESSED	M		
	155	COMPLY WITH MAOI 66-33, PARA 13	M		
		TYPE WORK PERFORMED			

CACZ08 * WORK CONTROL DOCUMENT * JC   1.DATE 80222 PAGE 1 OF 4 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/REC	5.DATE SCHED	6.DATE COMP
		MIPCAP	89081	

.PART NUMBER   9.ITEM SERIAL NR   10/12.TECH DATA/OPTIONAL
0F1-2-39-3   041281
CHG 5

10.MODEL/DESIGN/SERIES 11.STOCK NR
HEAT A1/A2/402D

WG-10 LAV10 5-19-89

13.MISC 14.NOUN/END ITEM NOUN
AUTOMATIC CONITION ACTUATORPAC
WOLFFRUM/MATEAC/65920

Mr. Richard Franklin

P/N	NSN	C/N
482139 (10-382420-3)	2925000085495OC	612296
482138 (10-382420-4)	2925000085405ON	35111A

15.DISP 16.FORM STATION	OP. NO.	17 WORK TO BE ACCOMPLISHED	18.MECH	19.	20.
N-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	.10 min M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.	M .15 min		
	020	DISASSEMBLE.	.80 min M		
	030	CLEAN AS REQUIRED.	.80 min M		
	040	INSPECT AS REQUIRED.	.15 min M		
	050	CHECK THE ELECTRICAL OPERATION OF SWITCH CONTAINED IN COVER & SWITCH ASSY. *OHMMETER → Hand-Tools	.5 min M		
	060	CHECK LEAKAGE RESISTANCE OF EACH CONTACT PIN & THE SWITCH HOUSING. MINIMUM ALLOWABLE RESISTANCE SHALL BE WITHIN SPECIFIED MEGOHMS. ACT: ACT: *500 VOLT MEGGER	M .5 min		
	070	REPAIR AS NECESSARY.	M .15 min		
	080	PLACE COVER & SWITCH ASSY IN OVEN & HEAT 1 HR. AT 350 DEG. F. TO LOOSEN	M		

(CONTINUED)

Delete

15.DISP 16.PDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19.	20.
Delete		POTTING COMPOUND.			
	090	WIPE SWITCH WITH A CLEAN CLOTH MOISTENED WITH METHYLETHYLKETONE OR EQUIVALENT. ALLOW TO AIR DRY WITHIN PRESCRIBED LIMITS. ACT HRS	M		
	100	POSITION SHIMS PREVIOUSLY REMOVED INSIDE THE COVER WITH HOLES LINED UP & INSTALL BRACKET & SWITCH ASSY USING 2 LARGE ALLEN HEAD SCREWS & LOCKWASHERS PREVIOUSLY REMOVED. TORQUE SCREWS WITHIN LIMITS. ACT IN/LBS *TORQUE WRENCH	M		
	110	AT THE MOMENT SWITCH PLUNGER TRIPS SWITCH TO ON, DISTANCE FROM PLUNGER ACTIVATING LEVER TRIP TO COVER PARTING SURFACE SHALL BE WITHIN PRESCRIBED LIMITS. ACT: INCH *DEPTH MICROMETER	M		
	120	REPLACE AS NECESSARY.	M		
Delete					
	130	LUBRICATE AS REQUIRED.	.5min M		
	140	REASSEMBLE	.30min M		
	150	TORQUE ADAPTER REQUIRED *TORQUE WRENCH	M		
	160	INSTALL SCREWS THEN SUCCESSIVELY & GRADUALLY TIGHTEN DIAGONALLY OPPOSITE SCREWS UNTIL DIAPHRAGM IS DRAWN DOWN EVENLY. TORQUE SCREWS WITHIN IN/LBS LIMITS. ACT:	M		
	*170	INSTALL SCREWS. SUCCESSIVELY & GRADUALLY TIGHTEN SCREWS UNTIL COVER IS DRAWN DOWN EVENLY. TORQUE SCREWS TO REQUIRED IN/LBS. ACT:	M		
	180	POSITION SCREW IN CENTER HOLE OF SWITCH HOUSING. THREAD SCREW INTO	.5min M		

(CONTINUED)

15.DISP 16.PDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
		HOUSING UNTIL MAX DEPTH IS REACHED . ACT: INCH			
	190	SPRING ADJUSTMENT DURING ASSEMBLY. OBTAIN ACT PRESS GAGE OF 4.4 PSI.	.15 m/I M		
	200	INSTALL THE ADAPTER IN HOLE OF COVER & SWITCH ASSY. TORQUE ADAPTER TO PRESCRIBED LIMITS. ACT: IN/LBS	M .10 m/I		
	210	CHECK & INSURE WASHER IS STILL ALIGNED. INSTALL SPRING & PLUG IN HOUSING. TORQUE PLUG WITHIN LIMITS ACT: IN/LBS	M .5 m/I		
	220	INSTALL VALVE ASSY IN SWITCH HOUSING TORQUE VALVE BODY TO PRESCRIBED LIMITS. ACT: IN/LBS	M .15 m/I		
	230	TEST SWITCH ASSY FOR LEAKAGE. ACT: LEAK DETECTOR TESTER Delete	M		
	240	TESTING.	.5 m/I M		
Covers-All:					
	250	CONNECT AIR HOSE ASSEMBLY	M		
	260	ADJUST THE ACTUATOR PRESS REGULATOR UNTIL ACTUATOR PRESSURE GAUGE INDICATES 7 PSI REQ NOT REQ	M		
	270	DEPRESS AND HOLD TEST BUTTON ON TEST SET TO DECREASE AIR PRESSURE ON SWITCH ASSEMBLY. THE ACTUATOR SWITCH SHALL NOT COME ON.	M		
	280	COMPLETE IAW T.O. SEL-2-32-3 PARA 7-3, SUB PARA 6	M		
	290	AFTER 13 PSI CHECK IS SATISFACTORILY COMPLETED, REPEAT AT 35 PSI	M		
	300	OBSERVE HOW LONG ACTUATOR SWITCH INDICATOR OF TEST REMAINS LIT. THIS IS THE "ON" TIME OF SWITCH ASSY. "ON" TIME SHALL BE WITHIN LIMITS. ACT: SEC.	M		
	310	ADJUST THE ACTUATOR PRESS REGULATOR UNTIL ACTUATOR PRESSURE GAUGE IN-	M		

(CONTINUED)

15.DISP 16.PDN

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.ACCM		
		DICATES / PSI. SECOND TO INLET ADAPTER OF SWITCH ASSEMBLY. REQ: NOT REQ: *LEAK DETECTOR TESTER*	.2MIN.		
	320	IF READJUSTMENT OF SCREW (20) WAS REQUIRED, REPEAT THE 13 PSI CHECK. ACT*	M .1MIN		
	330	USING A SUITABLE SOURCE, GRADUALLY APPLY 480 - 500 PSI OF CLEAN DRY AIR AT A RATE NOT EXCEEDING 50 PSI PER SECOND TO INLET ADAPTER OF SWITCH ASSEMBLY ACT ACT *LEAK DETECTOR TESTER*	M .5MIN		
	340	IMMERSE ACTUATOR ASSY IN A TANK OF CLEAN WATER AT ROOM TEMPERATURE & OBSERVE FOR LEAKAGE FOR 5 MINUTES. LEAKAGE SHALL NOT EXCEED ONE BUBBLE PER MINUTE. ACT	M .6MIN		
	350	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M .10MIN.		
	360	SAFETY WIRE	.15MIN. M		
	370	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M 1MIN.		
	380	OPERATIONS COMPLETED & PAPERWORK PROCESSED.	M.5MIN.		
	390	COMPLY WITH MAOI 66-36, PARA 13	M.1MIN.		
		TYPE WORK PERFORMED Overhaul			

CAEZ02 * WORK CONTROL DOCUMENT * JC	1.DATE 88202	PAGE 1 OF 2 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
	01	M1PCAP	89135	

7.PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
6869188	647	8D3-19-12-3 CHG 4 87289H

10.MODEL/DESIGN/SERIES | 11.STOCK NR
1F41-A1 Engine
Aircraft A-7D

Mechanic: Mr Richard Mr Franklin — Skill-code: A410 WG-10 — 533-3066 8254

13.MISC | 14.NOUN/END ITEM NOUN
CONTROL RELAY BOX PAC
-WOLFFRUM/MATEAC/65920

P/N	NSN	C/N
6869188 (M)	2925001565633CN	35113A 61230A

15.DISP 16.PDN/ *used hand tools - only.

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
W 43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M .15min		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M .20min		
	020	DISASSEMBLE.	M .30min		
	030	CLEAN AS REQUIRED.	M .5min		
	040	INSPECT AS REQUIRED.	M .10min		
* Add-Educations	050	REPAIR OR REPLACE AS NECESSARY.	M * Repair - depend on the mechanic, any time. Replace Quick 1/2 hr.		
	060	REASSEMBLE.	M .10min		
	* 070	CONNECTING.	M .1min		
	080	CONNECT THE LONG LINK HARNESS (6 FT LONG) TO THE SMALL RECEPTACLE ON THE REAR OF THE TEST BOX. Delete	M		
	090	CONNECT THE SHORT LINK HARNESS (2 FT LONG) TO THE LARGE RECEPTABLE ON THE REAR OF THE TEST BOX. Delete	M		
	✓100	CONNECT THE FREE END OF THE SHORT LINK HARNESS TO THE RECEPTACLE ON THE RELAY BOX.	M .1min		
	✓110	CONNECT THE FREE END OF THE LONG LINK HARNESS TO A 400 CPS FULL WAVE RECTIFIED ELECTRICAL SUPPLY VARIABLE	M .1min		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		BETWEEN 16V & 30V WITH A ZENER DIODE TO LIMIT ANY PEAKS OR SPIKES TO 33V. *TEST FIXTURE			
	120	TEST	.2 mins M		
	130	SET THE ELECTRICAL SUPPLY TO GIVE AN OUTPUT OF 16V.	M .2 mins		
	140	SET THE ELECTRICAL SUPPLY TO GIVE AN OUTPUT OF 30V.	M .2 mins		
	150	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M .5 mins		
	160	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M .1 mins		
	170	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M .5 mins		
	*175	COMPLY WITH MADI 66-36, PARA 13 TYPE WORK PERFORMED → REPAIR	M 3½ hrs.		

CACY12 * WORK CONTROL DOCUMENT * JC 1.DATE 88307 PAGE 1 OF 4 PAGES

PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE	6.DATE COMP
00510A		MTPCA	07074	

ART NUMBER ... 9.ITEM SERIAL NR ... 10/12.TECH DATA/OPTIONAL

...30870 1 (M) | TO MATHD ...

OEI 0 20 3 ... 00...

...MODEL/DESIGN/SERIES | 11.STOCK NR | CHG 11

... | 2920004000/27P01

...NOUN/END ITEM NOUN

IGNITION EXCITER ... PAC

WENDEL HAWKINS

...WORK ... 17.WORK TO BE ACCOMPLISHED

	000	RECEIVE, IDENTIFY & ATTACH PAPERWORK
	010	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.
	020	... TO MACHINE SHOP FOR REMOVAL OF ...
	030	DISASSEMBLE.
	040	... AND ... TERMINALS. REQ________ ... ________
	050	CLEAN AS REQUIRED.
	060	INSPECT.
	070	CHECK RESISTORS: FROM NO. 5 WHITE WIRE TO NO. 6 WHITE WIRE ACT______MEG ACT________MEG OHMMETER WHITE WIRE ON SPARK GAP TO WHITE WIRE ON V2. RESISTANCE ACT:________OHMS ACT:________OHMS XOHMMETER WHITE WIRE ON V4 TO NO.2 WHITE WIRE. RESISTANCE ACT:________OHMS ACT:________OHMS NO.4 BROWN WIRE TO NO.3 WHITE WIRE. CAPACITANCE, ..., APPLY 3000 VDC FOR 15 SECONDS MIN. ACTUAL________UF ACTUAL__________UF XCAPACITOR ANALYZER NO.4 BROWN WIRE TO WHITE WIRE ON

(CONTINUED)

15.DIE 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	INSP	
		SPARK GAP. CAPACITANCE [illegible] 3500 VDC FOR 15 SECONDS MINIMUM MINIMUM.			
		ACTUAL__________UF ACTUAL__________UF			
		WHITE WIRE ON SPARK GAP TO TERMINAL ON EXHAUST TIP END OF SPARK GAP. BREAKDOWN VOLTAGE			
		ACT:_______VDC ACT:__________VDC ← Tube Tester			
		*TESTER JET IGNITION SYSTEM NO.1 RED WIRE(CATHODE) TO NO.2 WHITE WIRE (ANODE) PLATE TO CATHODE FLOW .			
		ACT:________MILA ACT:_______MILA			
		WHITE WIRE ON SPARK GAP(CATHODE) TO NO.1 RED WIRE(ANODE) PLATE TO CATH ODE FLOW			
		ACT:________MILA ACT:________MILA			
	0[illegible]	ADJUST VOLTAGE UNTIL SPARK GAP [illegible] PULSE GENERATOR FIRES AT A RATE OF ONE PULSE EVERY [illegible] SEC. *JET IGNITION COMPONENTS TEST SET	M		
	[illegible]	OBSERVE THAT [illegible] SPARK GAP [illegible] [illegible] *VARIABLE SPARK GAP [illegible] PRESSURIZED	M		
	100	CAPACITOR ASSEMBLIES: CHECK CAPACI TANCE FROM LEAD TO LEAD			
		ACT:_______UF ACT:__________UF *CAPACITOR ANALYZER			
	[illegible]	APPLY A POTENTIAL OF 4[illegible] V DC BE TWEEN LEADS FOR A PERIOD OF NOT LESS THAN 15 SEC OR NOT MORE THAN 20 SEC. *TESTER JET IGNITION S[illegible]	M		
	120	RESISTANCE OF PRIMARY WINDING . ACTUAL__________OHM *OHMMETER	M		
	130	RESISTANCE OF SECONDARY WINDING . ACTUAL_________OHM	M		
	140	T2 RESISTANCE OF PRIMARY WINDING . ACTUAL_________OHM	M		
	150	RESISTANCE OF SECONDARY WINDING . ACTUAL________OHM	M		

[illegible] OPERATION NO.	17. WORK TO BE ACCOMPLISHED	18. [illegible]	19. [illegible]
160	RESISTOR ASSY. TEST CONNECT METER LEADS FROM BLUE LEAD TO COMMON. OBSERVE METER. ACTUAL__________OHMS *OHMMETER	M	
[illegible]	CONNECT METER LEADS FROM YELLOW TO COMMON. OBSERVE METER . ACTUAL__________OHMS	M	
[illegible]	[illegible] CHECK [illegible] CAPACITANCE [illegible] LEAD TO LEAD . ACTUAL __________UF *CAPACITOR ANALYZER	[illegible]	
[illegible]	[illegible] VALUE OF CAPACITANCE. . ACTUAL__________UF	[illegible]	
[illegible]	CHECK FOR CONTINUITY BETWEEN INPUT PINS B & C AND THEIR RESPECTIVE [illegible] TERMINALS. RESISTANCE SHALL BE LESS THAN ONE OHM. *OHMMETER	M	
[illegible]	CONTINUITY BETWEEN PIN A & [illegible] ALSO LESS THAN ONE OHM. ACTUAL__________OHM	M	
[illegible]	CHECK CAPACITANCE BETWEEN INPUT PIN B & HOUSING AND PIN C & HOUSING. ACTUAL________UF ACTUAL________UF *CAPACITOR ANALYZER	M	
2[illegible]0	CHECK INSULATION RESISTANCE BETWEEN INPUT PINS B & C. . ACTUAL_______MEGOHMS *MEGGER -- 500 VDC	M	
240	APPLY BREAKDOWN VOLTAGE OF 200 VDC AT FULL CHARGE FOR 15 SECONDS FROM EACH INPUT PIN B & C TO HOUSING. *JET IGNITION COMPONENTS TEST SET	M	
245	SOLDER RESISTORS TOGETHER IN SERIES CIRCUIT, INSTALL TUBING & HEAT SHRINK BY EXPOSING TO 347 DEG. F. FOR ONE MINUTE MINIMUM.	M	
250	REASSEMBLE.		

| CAEY12 * WORK CONTROL DOCUMENT * JC   1.DATE [illegible]   PAGE 4 OF 4 PAGES |

[illegible] 16.FDN/

STATION/OP NO.		17.WORK TO BE ACCOMPLISHED	18.MECH	[illegible]	[illegible]
	255	TEST OC*			
[illegible]	260 MTPIW	MOVE TO WELDING SHOP TO WELD [illegible]. TEST AS REQUIRED.	M		
10/0/?	260	TEST: EVACUATE EXCITER TO ONE INCH OF MERCURY & PRESSURIZE WITH [illegible] OF HELIUM. ~~*MASS SPECTROMETER~~ LEAK DETECTOR	M		
[illegible]	270	CLOSE VACUUM LINE & PRESSURIZE [illegible] EXCITER TO 200 +/- 20 [illegible] WITH DRY CARBON DIOXIDE HAVING A DEW POINT OF [illegible] DEG F ([illegible]) MAX & PURITY OF [illegible] PERCENT MINIMUM.	M		
	[illegible]	SUBMERGE EXCITER IN WATER, MAINTAINED AT [illegible] FOR ONE MINUTE. *LEAKAGE TEST & EVACUATION TOOL	[illegible]		
	[illegible]	TEST: TESTING FOR MAIN BURNER. MPS ROTOR SPEED (RPM) [illegible] MAINBURNER AUGMENTER NONE REQ ACTUAL________________ OVERSIZE TEST [illegible] MPS ROTOR SPEED (RPM) [illegible] MAINBURNER AUGMENTER ACTUAL__________ ACTUAL____________ MPS ROTOR SPEED (RPM) [illegible] MAINBURNER AUGMENTER ACTUAL_________ ACTUAL____________	M		
	[illegible]	SET RPM'S AT [illegible] & ENSURE THAT [illegible] FIRES CONSISTENTLY AT 21 KV MINIMUM FOR 10 SECONDS.	M		
	[illegible]	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	350	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O.S, TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M		
	360	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M		
	[illegible]	COMPLY WITH MAOI [illegible] PARA 1. TYPE WORK PERFORMED________________	M		

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2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
38643A		MTPCAP	89094	

7. PART NUMBER: 311D19165

9. ITEM SERIAL NR:

8/12. TECH DATA/OPTIONAL: TO MAT08-13 / 6J1 2 21 3 / CHG 11 — 071211

10. MODEL/DESIGN/SERIES: J77 15

11. STOCK NR: 2915000833452

13. MISC / 14. NOUN/END ITEM NOUN: TEMP AMPLIFIER AMPLIFIER PAC / PERRY/MATLAC/65920

Lead · · · · by

15. DISP 16. PDN/

OPERATION NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19.	20.
010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	T m		
020	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	m		
030	INSPECTION (VISUAL)	m		
035	FULL COOLING TUBE TEST; NO LEAKAGE ALLOWED.	m		
040	(PRE-TEST) RESISTANCE CHECK	m 20 min warmup 4 min setup		
050	POWER APPLICATION TEST (PRE TEST) DIFFERENTIAL CURRENT - ACT______________MA. R100 COUNTER-CLOCKWISE RESULTANT-ACT_________________MV. R100 CLOCKWISE- RESULTANT-ACT_________________MV.	m		
060	NULL VOLTAGE COMPENSATION (PRE-TEST)	m		
070	STATIC GAIN TEST (PRE-TEST)	m		

Operation 040:

CONNECTOR	PINS	OHMS (ACT)
J1	"A" AND "B"	___________
J2	"A" AND "B"	___________
J3	"B" AND "C"	___________

Operation 070:

MILLIVOLTS FROM NULL	DIFFERENTIAL OUTPUT ACT (MA.)
+1	__________
+5	__________
+10	__________
+3	__________
0	__________

(CONTINUED)

CAEM04 * WORK CONTROL DOCUMENT * JC		1.DATE 88239	PAGE 2 OF 5 PAGES		
15.DISP-16.PDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		-1 ____________ -5 ____________ -10 ____________ -3 ____________ 0 ____________			
	080	TEMPERATURE VS. ENGINE SPEED TEST (PRE TEST) ALTERNATOR FREQUENCY CPS / MILLIVOLT VALVE ACT 840 ____________ 829 ____________ 810 ____________ 798 ____________ 680 ____________ 500 ____________ 829 ____________	M		
	090	FREQUENCY RESPONSE TEST (PRE-TEST) 27 LINES, FREQUENCY .30 TO .55CPS ACT:________________ 35 LINES, FREQUENCY .45 TO .84 CPS ACT:________________	M		
	100	SPEED DERIVATIVE TEST (PRE-TEST) .1 CPS (23-29MV)_______________ACT .2 CPS (45-57MV)_______________ACT .3 CPS (68-86MV)_______________ACT .5 CPS (116-157MV)_______________ACT	M	End initial form	
	120 INFO	IF ALL TEST PASSES, MOVE TO STEP 340	M		
	130	DISASSEMBLY AS REQ. 45 min	M		
	140	**CLEAN AS REQ.** 20 min	M		
	150	**INSPECT PARTS:**	M		
	160	INSPECT POTENTIOMETER: 5 min	M		
	170	REPAIR OR REPLACE AS REQ. tube 2hr / Glom. ½ hr / connectors ½ hr	M		
	180	REASSEMBLY OF SUBASSEMBLIES Potting: 10 min → oven 1 hr Safety: 20 min	M		
	190	REASSEMBLY OF COMPONENTS see notes	M		

6.9

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| 15.DISP-16.PDN/---

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
	200	SATRUABLE-REACTOR CURRENT TEST RESISTANCE OF R101 DECADE BOX ACT________________	M		
	210	TOP SPEED BREAK TEST RESISTANCE OF R103 DECADE BOX ACT:________________	M		
	220	THERMOCOUPLE AMPLIFIER TEST R104 ACT________________ R106 ACT________________	M		
	230	SLOPE TEST R102 ACT:________________	M	N/A	
	240	FREQUENCY RESPONSE TEST 27 LINES. FREQUENCY .30 TO .35 CPS ACT______________ 35 LINES, FREQUENCY .45 TO .54 CPS ACT______________	M		
	250	SPEED DERIVATIVE TEST .1 CPS (23-29MV)______________ACT .2 CPS (45-57MV)______________ACT .3 CPS (68-86MV)______________ACT .5 CPS (116-1??MV)____________ACT	M		
	260	INSTALL RESISTOR	M		
[illegible] perform the [illegible]	270	RESISTANCE CHECK CONNECTOR PINS OHMS (ACT) J1 "A" AND "B" __________ J2 "A" AND "B" __________ J3 "A" AND "B" __________	M	Normally this is the hot test	
	280	POWER APPLICATION TEST DIFFERENTIAL CURRENT- ACT______________MA. R100 COUNTER-CLOCKWISE RESULTANT-ACT:________________MV. R100 CLOCKWISE- RESULTANT-ACT:________________MV.	M		
	290	NULL VOLTAGE COMPENSATION	M		
	300	STATIC GAIN TEST MILLIVOLTS FROM NULL / DIFFERENTIAL OUTPUT ACT (MA.) +1 __________ +5 __________ +10 __________ +3 __________	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"I"	20"Q"
		0 ________________			
		-1 ________________			
		-5 ________________			
		-10 ________________			
		-3 ________________			
		0 ________________			
	310	TEMPERATURE VS ENGINE SPEED TEST	M		
		ALTERNATOR FREQUENCY CPS / MILLIVOLT VALVE ACT.			
		640 ________________			
		629 ________________			
		610 ________________			
		758 ________________			
		680 ________________			
		660 ________________			
		627 ________________			
	320	FREQUENCY RESPONSE TEST			
		27 LINES, FREQUENCY .30 TO .35 CPS	M		
		ACT:______________			
		35 LINES, FREQUENCY .40 TO .54 CPS			
		ACT:______________			
	330	SPEED DERIVATIVE TEST			
		.1 CPS (23-29MV)________________ACT	M		
		.2 CPS (45-57MV)________________ACT			
		.3 CPS (68-86MV)________________ACT			
		.5 CPS (116-157MV)______________ACT			
	340	SHOCK TEST 10 min			
		OUTPUT DIFFERENTIAL CURRENT.	M		
		ACT:________________			
	350	MECHANICAL PRESSURE TEST 10 min			
		OUTPUT DIFFERENTIAL CURRENT.	M		
		ACT:________________			
	360	VIBRATION TEST 30 min	M		
	[redacted]	HIGH TEMPERATURE TEST	M		
	380	COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING.	M 5 min		
	390	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.	M 5 min		
	400	OPERATIONS COMPLETE, PAPERWORK PROCESSED.	M 2 min		

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15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	410	COMPLY WITH MAUI 66-36, PARA 13 TYPE WORK PERFORMED__________________	[illegible]		

CAEA01 * WORK CONTROL DOCUMENT * 72-10 1.DATE 86121

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
50217A		MTPCAP	86198	

7.PART NUMBER: 44387
9.ITEM SERIAL NR:
8/12.TECH DATA/OPTIONAL: PO-MAT86-3, 8E1-8-9-3, CHG 9, 84153H
10.MODEL/DESIGN/SERIES: TF33-PW102
11.STOCK NR: 2925011615596RV
13.MISC
14.NOUN/END ITEM NOUN: IGNITION EXCITER

15.DISP-STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
W-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE.	M		
	030	CLEAN AS REQUIRED.	M		
	040	INSPECT AS REQUIRED.	M		
	050	CAPACITOR TEST: TRIGGER CAPACITOR, APPLY 5000VDC BETWEEN CAPACITOR TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS. LEAKAGE. . ACTUAL______________MICROAMP. *CAPACITOR BRIDGE TESTER	M		
	060	CHECK CAPACITANCE. . ACTUAL_________________UF	M		
	080	CHECK CAPACITANCE. . ACTUAL________________UF	M		
	090	TEST 3 STORAGE CAPACITORS AS A CONNECTED GROUP. APPLY 4000VDC BETWN FREE END ON INTER-CONNECT LEAD & GROUND ON CASE. LEAKAGE . ACTUAL__________MICROAMP	M		
	100	CHECK CAPACITANCE AT SAME TERMINAL . . ACTUAL________________UF	M		

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	110	FILTER TEST: APPLY 300 VDC BETWN "B" PIN & GROUND FOR NO MORE THAN 30 SEC THERE MUST BE NO SIGN OF BREAKDOWN.	M		
	120	CHECK LEAKAGE BETWEEN EITHER TERMINAL AND CASE: . ACTUAL________________MEGOHMS *VACUUMTUBE VOLTMETER	M		
	130	CAPACITANCE. . ACTUAL____________________UF *CAPACITOR BRIDGE TESTER	M		
	140	RESISTOR TEST (29): MEASURE RESISTANCE BETWN UPPER TERMINAL OF RESISTOR LEAD & CASE. . ACTUAL_________________OHMS *VACUUMTUBE VOLTMETER	M		
	160	TEST RESISTOR ASSY (45) MEASURE RESISTANCE BETWEEN RESISTOR LEADS. . . ACTUAL________________MEGOHMS	M		
	170	TEST EACH RESISTOR INDIVIDUALLY; MEASURE RESISTANCE BETWN RESISTOR TERMINALS. . ACTUAL________________MEGOHMS	M		
	180	RECTIFIER TEST: USE HIGH VOLTAGE REGULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT. . ACTUAL________________MEGOHMS *TEST FIXTURE	M		
	190	RAISE VOLTAGE UNTIL MILLIAMMETER SHOWS READING OF 100MA. FORWARD VOLTAGE DROP ACROSS RECTIFIER. . ACTUAL_________________VOLTS *DC VOLTAGE REGULATOR	M		
	240	READ VOLTAGE OVER A PERIOD OF 30 SECONDS. ACTUAL_______________VOLTS	M		

15.DISP STATION	16.PDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	250	HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO WHICH PRIMARY LEADS ARE ATTACHED. ACTUAL_______________OHM *OHMMETER	M		
	260	ADJUST FOR GAP & INTERNAL PRESSURE. ACTUAL________INCH ACTUAL_______PSIG *IGNITION OUTPUT TESTER	M		
	270	REPAIR OR REPLACE AS NECESSARY.	M		
	280	TO CLINCH KNURLED FLANGE TO CASE, TORQUE A NUT AGAINST OUTER WALL OF CASE. ACTUAL____________IN/LB *TORQUE WRENCH.	M		
	300	ALL SCREWS & LOCKNUTS SHOULD BE TORQUED. ACTUAL_____________IN/LB *TORQUE WRENCH	M		
	310	TEST IAW T.O. 8E1-8-9-3, PARA 2-36 SUB PARA "A" *TEST FIXTURE	M		
	340	RAISE TRANSIFIER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA-SCOPE SHOWS FIRST PEAK. ACTUAL_____________VOLTS	M		
	350	THE FIRST HALF CYCLE SHOULD BE NEGA-TIVE & MUST SHOW AT LEAST 2 POSITIVE PEAKS & 2 NEGATIVE PEAKS WITHIN THE PERIOD OF 1 MILLISECOND. *TEST FIXTURE	M		
	360	REASSEMBLE.	M		
	370	TEST STORAGE CAPACITOR; RAISE INPUT VOLTAGE TO 14V FOR NO MORE THAN 10 SECONDS. VALUE ACTUAL______________VOLT *VOLTASCOPE	M		
	380	TEST: INPUT VOLTAGE 14	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		INPUT CURRENT SPARK RATE ACTUAL________AMP ACTUAL_________SR INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE ACTUAL________AMP ACTUAL_________SR INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE ACTUAL________AMP ACTUAL_________SR			
	390	TIGHTEN HEX NUTS AT INPUT END, LARGE NUT SHOULD BE TORQUED & THE 2 SMALLER NUTS. ACTUAL_____FT/LBS ACTUAL_______IN/LB *TORQUE WRENCH	M		
	400	SOLDER UNIT.	M		
	410	TEST EXCITER FOR LEAKS USING A PROBE WITH 14 PSIG. LEAKAGE. ACTUAL_____________CC *VEECO LEAK DETECTOR	M		
	420	SUBMERGE EXCITER IN WATER HEATED TO MINIMUM OF 49 DEG C (120 DEG F) FOR 1 MINUTE.	M		
	430	GAS CHARGING: BAKE EXCITER 15 MIN. AT 275 DEG F. THEN TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR ADDITIONAL 15 MINUTES.	M		
W-41	440	PAINT.	M		
	450	BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. OR AIR DRY.	M		
	460	TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK GAP OF 0.100 INCH. ADJUST NITROGEN INLET UNTIL GAGE HOLDS STEADY.	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		ACTUAL____________PSIG *IGNITION OUTPUT TESTER			
	470	TEST: INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE ACTUAL________AMP ACTUAL________PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE ACTUAL________AMP ACTUAL__________PER 10 SEC INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE ACTUAL_________AMP ACTUAL__________PER 10 SEC	M		B
	490	APPLY 24V INPUT CURRENT. OBTAIN ONE (1) OF THE FOLLOWING: METER READING 72.5 78.0 83.0 87.5 91.5 ACTUAL_____________________	M		
	500	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	545	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M		
	546	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED_______________	M		
	550	OPERATIONS COMPLETED & PAPERWORK PROCESSED.	M		

7.4)

CAEMOQ * WORK CONTROL DOCUMENT * JC   1.DATE 88239 PAGE 1 OF 4 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
30645A		MTPCAP	89094	

WR NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
635E490001		PO MAT08-13
		TOPS 101 830141H
10.MODEL/DESIGN/SERIES	11.STOCK NR	6J1 2-25-3 88061H
J79-17	2915001338007PL	CHG 10

13.MISC 14.NOUN/END ITEM NOUN
AMPLIFIER, TEMP   PAC
PERRY/MATEAC/65920

James Dye

15.DISP STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"I"	20"Q"
		72 10 ITEM 27917A			
	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	T M		
	020	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	M		
TEST	030	INSPECTION (VISUAL)	M		
	040	PERFORM FUEL COOLING TUBE TEST (PRE-TEST) (PARA 11-5C) FUEL TEMP: ACT__________________DEG.	M		
	050	PERFORM INSULATION RESISTANCE TEST (PRE-TEST) ACT______________________MEGOHMS OVEN ACT________________MEGOHMS	M		
	060	SET UP AMPLIFIER FOR PRE TEST (PARA 11-7)	M		
	070	PERFORM OPEN THERMOCOUPLE PRE-TEST.	M		
order	080	NULL VOLTAGE COMPENSATION (PRE-TEST)	M		
	090	PERFORM POTENTIOMETER RANGE TEST (PRE-TEST)	M		
	100	STATIC GAIN TEST (PRE-TEST)	M		

MILLIVOLTS FROM NULL	DIFFERENTIAL OUTPUT ACT (MA)
+1	

(CONTINUED)

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15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED		18.MECH	19"P"	20"Q"
		+5	________________			
		+10	________________			
		-1	________________			
		-5	________________			
		-10	________________			
	110	TEMPERATURE VS. ENGINE SPEED TEST (PRE-TEST) NORMAL SCHEDULE		M		
		ALTERNATOR FREQUENCY HZ	T 5 LIMITS ACT			
		600	________________			
		700	________________			
		740	________________			
		755	________________			
		770	________________			
		792	________________			
		804	________________			
		816	________________			
		825	________________			
		840	________________			
	120	TEMPERATURE VS ENGINE SPEED RESET TEST (PRE-TEST)		M		
		ALTERNATOR FREQUENCY HZ	T 5 LIMITS ACT			
		792	________________			
		840	________________			
	130	ACCELERATION (STALL) RESET (PRE-TEST)		M		
		ALTERNATOR FREQUENCY HZ	MILLIVOLT VALVE ACT			
		770	________________			
		804	________________			
	140	COMBAT RATING RESET		M		
		ALTERNATOR FREQUENCY HZ	T 5 VALUES ACT			

(CONTINUED)

CAEM08 * WORK CONTROL DOCUMENT * JC 1.DATE 88239 PAGE 3 OF 4 PAGES

15.DISP-16.PDN/-

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"?"	20"Q"
		770 ____________________ 804 ____________________			
	150	CHECK RELATIONSHIP OF ? 5 FLATS.	M		
	160	ACCELERATION RESET RESPONSE TEST (PRE TEST) PLN DISPLACEMENT ACT____________%	M		
	170	FREQUENCY RESPONSE TEST (PRE-TEST)	M		
	180	SPEED DERIVATIVE TEST (PRE-TEST)	M		
	190	OBTAIN THE POSITIVE & NEGATIVE OUTPUT MILLIAMPERE SWEEPS AT ALL THREE "LEFO" SETTINGS. .1 CPS SWEEP ACT_______________MA .3 CPS SWEEP ACT_______________MA .5 CPS SETTING ACT_______________MA	M		
	200	SPEED DERIVATIVE RESPONSE TEST (PRE TEST)	M		
	210 Test	HIGH TEMPERATURE TEST.	M		
	220 Test	COLD TEMPERATURE TEST.	M		
	230	TROUBLESHOOT.	M		
	240	IF ALL TESTS PASS MOVE TO STEP 33	M		
	250	DISASSEMBLE AS REQUIRED.	M see notes		
	260	CLEAN AS REQUIRED. included	M		
	~~270~~ omit	INSPECT AS DIRECTED. RESISTANCE ACT______________OHMS TORQUE CHECK ACT____________OZ/IN	M		
	~~280~~ omit	REPAIR OR REPLACE AS REQUIRED.	M		
	~~290~~ omit	REASSEMBLE SUB-ASSY'S AS DIRECTED.	M		
	~~300~~ omit	REASSEMBLE COMPONENTS AS DIRECTED.	M		

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15.DISP-16.PDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	310	PERFORM FINAL ASSEMBLY AS DIRECTED.	M		
	320	FINAL INSPECTION & PERFORMANCE TESTS this is the	M		
	330	COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING.	M 5		
	340	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS. OPERATIONS COMPLETE & PAPERWORK PROCESSED.	M 2		
	350	COMPLY WITH MAGI 66-36, PARA 13 TYPE WORK PERFORMED________	M		

Hand carry
units to

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2. ~~ORIG/PROD~~ NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
38669A		MTPCA	87094	

7. PART NUMBER
10-353975-2

9.ITEM SERIAL NR

8/12.TECH DATA/OPTIONAL
PO MATOO-16
8E1 2-36-13 850928H
CHG 8

10.MODEL/DESIGN/SERIES
J79 15/17

11.STOCK NR
2925009921235PL

LARRY WARE

13.MISC 14.NOUN/END ITEM NOUN
IGNITION EXCITER PACI
PERRY/MATEAC/65920

15.DISP-16.POH/

STATION OP NO.		17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS, TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	M		
	025	ITEMS CONTAIN PRECIOUS METALS, SEE MA01 65 4 FOR PROCESSING & CONTROL.	M		
clean	030	cleaning ~~INSPECTION~~ (VISUALLY)	M		
	035	FUNCTIONAL TEST	M		
	040 MTPEM	MOVE TO MACHINE SHOP TO REMOVE LID.	M		
	045	DISASSEMBLE	M		
	050	CLEAN AS REQUIRED.	M		
	055	INSPECT AS REQUIRED.	M		
	060	TEST TUBE ASSEMBLY. .2	M		

Functional test (op 035):

APPLIED VOLTAGE	ACTUAL INPUT CURRENT	ACTUAL SPARK RATE	ACTUAL OUTPUT VOLTAGE
14	_______	______	N/A
24	_______	______	_______
30	_______	______	N/A

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	065	TEST SPARK GAP. ACT ____________________VDC .3 5 min	M		
	070	TEST RESISTOR ASSEMBLY RESISTANCE ACT___________OHMS .2 5 min	M		
	075	TEST TRANSFORMER VIBRATOR ASSEMBLY RESISTANCE ACT___________OHMS	M		
	080 ✓	CAPCIATOR ASSEMBLY GREEN LEAD - WHITE A LEAD ACT ________________MICROFARAD .4 10 min YELLOW LEAD - WHITE B LEAD ACT ________________MICROFARAD	M		
	085	TEST FILTER ASSEMBLY CONNECTOR INPUT PIN - HOUSING ACT ________________MICROFARAD *INSULATION RESISTANCE CONNECTOR INPUT PIN - HOUSING .05 ACT ________________MEG *500 VOLT MEGGAR	M was time	item	replacement
	090	REPAIR OR REPLACE AS REQUIRED.	M		
	095	REASSEMBLY	M		
	100	TORQUE: NUT (37) ACT________LB IN. NUT (14) ACT________LB IN. NUT (27) ACT________LB IN. SCREW (19) ACT______LB IN. PLUG (3) ACT________LB IN.	M		
	105	TEST EXCITER ELECTRICALLY	M		
	110 MTPIW	MOVE TO MTPIW (WELDING SHOP) TO HAVE LID WELDED.	M		
	115	LEAK CHECK EXCITER.	M		
	120	EVACUATE AND PURGE EXCITER. oven time - cool time 45.	M		

Table for OP 105:

APPLIED VOLTAGE	ACTUAL INPUT CURRENT	ACTUAL SPARK RATE	ACTUAL OUTPUT VOLTAGE
14	_______	______	N/A
24	_______	______	_______
30	_______	______	N/A

Station for OP 110: 0-05

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15.DISP STATION	16.PDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	123	LEAK CHECK EXCITER (AROUND PLUG) (USING THE WATER METHOD)	M		
	125	PAINT	M		
	130	TEST EXCITER APPLIED VOLTAGE / ACTUAL INPUT CURRENT / ACTUAL SPARK RATE / ACTUAL OUTPUT VOLTAGE 14 ______ ______ N/A 24 ______ ______ ______ 30 ______ ______ N/A	M		
	140	EXCITER 10-353975 2 (RADIOACTIVE) MAY BE REWORKED TO 10-353975 3 (NONRADIOACTIVE). IF DONE, REIDENTIFY TO 10 353975 3 OR (10605539P3). RADIOACTIVE STICKER WILL NOT BE USED IF REIDENTIFIED.	M [illegible] hazard.		
	150	COMPLETE & FORWARD AFTO 349 TO DATA PROCESSING.	M		
	155	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M		
	160	OPERATIONS COMPLETE, PAPERWORK PROCESSED.	M		
	165	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED________________	M		

3.7

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2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
38694A		MTPCAP	89094	

7. PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
317193-7		TO MAT08 13 10L2 2 4/ 13 0024H CHG 19

10.MODEL/DESIGN/SERIES	11.STOCK NR
J77 15/17	2925009637064

13.MISC 14.NOUN/END ITEM NOUN
SOLENOID ASSY PAC
PERRY/MATLAC/65920

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	ALL REFERENCES ARE TO BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	M		
	030	DISASSEMBLE SOLENOID ASSY.	M		
	040	REPLACE VALVE ASSY (22)	M		
	050	RECORD QUANTITY & THICKNESS OF WASHERS (16) FOR REASSEMBLY PURPOSES	M		
	060	RECORD QUANTITY & THICKNESS OF SHIMS (25) AND WASHERS (26) FOR REASSEMBLY PURPOSES.			
	~~070~~	~~CLEAN PARTS~~ AS REQUIRED.	M		
	~~080~~	~~INSPECT PARTS.~~	M		
	090	CHECK RESISTANCE OF COIL ASSEMBLY ACT__________OHMS AND__________OHMS	M		
	100	PERFORM DIELECTRIC TEST.	M		
	110	REASSEMBLE SOLENOID ASSEMBLY	M		
	~~115~~	IF NEW PIN IS REQ. SEND ASSEMBLY TO MTPIW FOR WELDING. REQ.__________NOT REQ.__________	M		
	120	TEST AS REQUIRED.	M		

CAEM07 * WORK CONTROL DOCUMENT * JC 1.DATE 80232 PAGE 2 OF 2 PAGES

15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19."S"	20."Q"
	130	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	140	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O. TCTO'S, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.	M		
	150	COMPLY WITH MASO 66-36, PARA 13 TYPE WORK PERFORMED________________	M		

CAEM02 * WORK CONTROL DOCUMENT * JC	1.DATE 88237 PAGE 1 OF 3 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
30710A		MTPCAP	89074	

7. PART NUMBER	9.ITEM SERIAL NR	10/12.TECH DATA/OPTIONAL	
10-397625-1		8E1 2-36 23	87082H
		CHG 1	
10.MODEL/DESIGN/SERIES	11.STOCK NR	8E1 2-36 3	87121H
077	2925011325027PL	CHG 12	
		8E1 2-36 506	88001H
13.MISC / 14.NOUN/ENG ITEM NOUN		8E1-2-36-506C	88340H
IGNITION EXCITER (LOW SMOKE/AC		8E1 2-36 506L	84300H
PERRY/MATLAC/05720		8E1-2 36 506I	88000H
		8E1 2-36 506H	[illegible]

DONELDA STROUD

15.DISP STATION	16.PDM/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19.**	20.**
		F 10600781P3 2925007927904PL 30070A			
	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	020	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS, AND TOLERANCES REQUIRING COMPLIANCE.	M		
022 INS CLEAN	025	ITEMS CONTAIN PRECIOUS METALS, SEE MAGI 65-4 FOR PROCESSING & CONTROL.	M		
	030 MTPCM	RECEIVE EXCITER: REMOVE LID AND WELDS: RETURN TO MATPCA.	M		
	040	DISASSEMBLE	M		
	050	HOUSING ASSEMBLY, CHECK FLANGES MINIMUM HEIGHT ACT:____________INCH REWORK IAW 8E1 2-36 23 PARA 5-4.H. (6). REWORK: REQ__________ NOT REQ__________	M		
	060 MTPCM	MILL HOUSING EDGE FOR HOUSING EXTENSION: ACT:____________INCH	M		
	070 MTPIW	WELD EXTENSION ON THE HOUSING	M		
	080 MTPIW	WELD BRACKETS AND STUDS TO MODIFIED HOUSING. WHEN FINISHED MTPIW EILL RETURN BOX TO MTPCA.	M		
	090 MTPCA	MTPCA WILL MODIFY EXCITER AS REQ. BY TCTO.	M		

CAEM02 * WORK CONTROL DOCUMENT * JC		1.DATE 88237 PAGE 2 OF 3 PAGES			
15.DISP-16.PDN/					
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	100	*TEST HOUSING AND TRANSFORMER ASSY. (60); MEASURE PRIMARY AND SECONDARY RESISTANCE. GREENWIRE WHITEWIRE__________ACT OHMS BROWNWIRE-RED WIRE__________ACT OHMS * OHMETER	M		
	110	*TEST ELECTRON TUBE ASSY. (25) (26) INVERSE CURRENT FLOW___________ACT MA OPERATING CURRENT_____________ACT MA * 11-6552 ELECTRON TUBE TEST SET	M		
	120	*TEST RESISTOR ASSY. (44) RESISTANCE__________________ACT OHMS * OHMETER	M		
DELETE & COMBINE WHERE USED	130	TORQUE VALUES: SCREWS (58) 2______________ACT LB/INS SCREW (52) 1______________ACT LB/INS NUTS (59) 4______________ACT LB/INS NUT (15) 1______________ACT LB/INS SCREW (31) 2______________ACT LB/INS SCREW (10) 2______________ACT LB/INS NUT THREAD (13)1__________ACT LB/INS	M		
	140	WHEN COMPRESSING CAPACITOR ASSEMBLY THROUGH FORCE GUAGE_________ACT LBS OF FORCE WERE APPLIED.	M		U-41
	145 MTPCM	CUP GOES TO MACH. SHOP TO BE CUT OFF AT SCRIBED LINE.	M		
155 ASSY	150 MTPIW	THE BOX MAY HAVE TO GO TO MTPIW AFTER ANY ONE PROCEDURE TO HAVE THE PLATE ON THE VIBRATOR ASSY. (51) WELDED TO THE PARTITION. AT THIS TIME THE FILTER ASSY. CONNECTOR AND CUP COULD BE WELDED TO THE HOUSING. EXCITER WILL THEN BE RETURNED TO MTPCA FOR TESTING.	M		
COMBINE	160 MTPCA	EXCITER WILL BE TESTED IAW 8E1-2-36-3 EXCEPT FOR DIFFERENCES NOTED IN TCTO.	M		
ASS	170 175	"BEFORE" COVER TEST: A/B 70 VAC_________ACT SPARK RATE (S/R) 115 VAC_________ACT S/R____ACT OUTPUT 120 VAC_________ACT S/R MAIN 14 VDC__________ACT S/R 24 VDC______ACT S/R_____ACT OUTPUT 30 VDC______ACT S/R	M		
	180 MTPIW	FINISH PACKING EXCITER THEN SEND WITH COVER TO MTPIW FOR	M		

(CONTINUED)

1..DIGP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20
		WELDING OF COVER TO HOUSING. MTPIW WILL SEND BACK TO MTPCA			
	190 MTPCA	TEST FOR LEAKAGE, EVACUATE, AND PURGE IAW 8E1 2-36-3.	M		
	195	TORQUE PLUG (13): ACT:______________IN/LB	M		
	200	TEST EXCITER "AFTER" TEST A/B 90 VAC_____________ACT S/R 115 VAC_____ACT S/R_______ACT OUTPUT 120 VAC_____________ACT S/R MAIN 14 VDC_________ACT S/R 24 VDC______ACT S/R_____ACT OUTPUT 30 VDC______ACT S/R	M		
	210	TEST USING 11-4700-1 TESTER AND 11-9600 SPARK GAP ASSY. TESTER. 24 VOLTS DC INPUT ACT: SEC FIRED______________________ FIRING STOPS ACT: KR___________________________	M		
	220	CLEAN AS REQUIRED	M		
	230	PAINT AS REQUIRED	M		
	240	MARK NEW PART NUMBER 10 397625 1 (GE 106C5281P5), A LETTER R IN REV BLOCK, AND ORIGINAL SERIAL NUMBER, CURRENT, VOLTAGE, AND TYPE LETTERS ON NEW IDENT. PLATE. DO NOT APPLY RADIOACTIVE WARNING PLATE AS WARNING NO LONGER APPLIES. (AS PER TCTO) INSTALL IDENT. PLATES.	M		
	250	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS, AND APPLICABLE PROCESS ORDERS.	M		
	260	OPERATIONS COMPLETED & PAPERWORK FORWARDED.	M		
	270	COMPLY WITH MA01 66-36, PARA 13 TYPE WORK PERFORMED_______________	M		

CAEC07 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89045 PAGE 1 OF 3 PAGES.

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
		MTPCAP	89094	

7. ART NUMBER | 9.ITEM SERIAL NR | 8/12.TECH DATA/OPTIONAL
PO MAT87 16
PO MAT87 1
PO MAT87 3

10.MODEL/DESIGN/SERIES | 11.STOCK NR
TF33 37/11A | 2925007737217RV | GE1 2 22 103 8830GH
CHG 20
GE1 2 22 103 1 7721GH

13.MISC | 14.NOUN/END ITEM NOUN
IGNITION EXCITER PAC LARRY WARE
JENNINGS/MATEAC/65720

15.DISP STATION	16.PDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		P/N 378205 P/N 10-187860-1 MET1PA 98001(A) (1) C/N 49711A P/N 10 617860 1 (SUPERCEDES 10-187860-1) S/N 2925011318761RV			
W 43	010	RECEIVE, IDENTIFY & ATCH PAPERWORK.	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.	M		
V-41	TEST 020	MOVE TO MACHINE SHOP & REMOVE LID.	M		
	030	DISASSEMBLE.	M		
	040	CLEAN AS REQUIRED.	M		
	050	INSPECT.	M		
	051	INSPECT HOUSING ASSEMBLY HEIGHT ACT____________INCH. REPLACED NEW YES___ NO____ REPAIR REQ______NOT REQ__________	M		
W 41	055 MTPCA	MOVE UNDERSIZE HOUSINGS TO WELDING FOR EXTENSION STRIPS	M		
	060	MEASURE RESISTANCE OF FILTER, BETWEEN INPUT PIN & OUTPUT LEAD. . ACTUAL__________OHM *OHMMETER	M		
O-35	070 MTPIW	WELD FILTER AND CONNECTORS.	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19	20 Q
		REQ:_________NOT REQ:____________			
	080	MEASURE CAPACITANCE BETWEEN INPUT PIN & HSG. . ACT______________UF *CAPACITOR ANALYZER*	M		
	090	CHECK INSULATION RESISTANCE BETWEEN INPUT PIN & FILTER HOUSING BY APPLYING 400 VDC. INSULATION RESISTANCE . ACT____________MEGOHMS *400 VOLT MEGGER*	M		
	100	(TRANSFORMER) MEASURE PRIMARY RESISTANCE BETWEEN BLACK LEAD & GREEN LEAD. ACT____________OHM *OHMMETER*	M		
	110	MEASURE SECONDARY RESISTANCE BETWEEN WHITE & RED LEAD OF TRANSFORMER. . ACT____________OHM	M		
	120	CHECK CAPACITANCE OF CAPACITOR, P/N 10-107202 *CAPACITOR ANALYZER* ACT:__________UF	M		
	130	CAPACITANCE BETWEEN NO 1 LEAD AND GROUND ACT______________UF	M		
	140	CAPACITANCE BETWEEN NO 2 LEAD AND GROUND ACT_____________UF	M		
	150	CAPACITANCE BETWEEN NO 3 & 5 LEAD . ACT____________UF	M		
	160	CAPACITANCE BETWEEN NO 4 & 5 LEAD . ACT____________UF	M		
	170	APPLIED VOLTAGE BETWEEN NO 1 LEAD & GROUND ACT____________VDC APPLIED VOLTAGE BETWEEN NO 2 LEAD & GROUND ACT____________VDC APPLIED VOLTAGE BETWEEN NO 3 & 5 LEAD ACT______________VDC APPLIED VOLTAGE BETWEEN NO 4 & 5 LEAD ACT______________VDC	M		

(CONTINUED)

CALC07 * WORK CONTROL DOCUMENT * 72-10 1.DATE [illegible] PAGE [illegible] OF [illegible] PAGES
15.DISP 16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19[illegible]	20[illegible]
		THERE SHALL BE NO VOLTAGE BRK DN OR FLASHOVER OF ANY SECTION DURING A 15 SECOND PERIOD OF APPLIED VOLTAGE. *JET IGNITION COMPONENT SET*			
	180	MEASURE RESISTANCE OF RESISTOR (6) & RESISTORS (7) WHICH TOGETHER MAKE UP RESISTOR ASSY. RESISTANCE READING FOR RESISTOR (6) ACTUAL ______________MEGOHMS RESISTANCE READING FOR RESISTORS (7) . ACT ______________ M ______________OHM *OHMMETER*	M		
	[illegible]	VOLTAGE BREAKDOWN FOR SPARK GAP ASSY . ACT ______________VDC ______________VDC *JET IGNITION COMPONENT TEST SET*	M		
	[illegible]	CHECK RECTIFIER ASSEMBLY FOR CONT INUITY OF RECTIFIERS. ACT ______________________________MA * ELECTRON TUBE TEST SET *			
	200	CHECK COIL FOR CONTINUITY BETWEEN EA TERMINAL & THE CONTACT PIN IN THE OUTLET. *OHMMETER*	M		
	210	REPAIR OR REPLACE AS NECESSARY VIBRATOR SHALL BE REPLACED AT EACH IGNITION EXCITER OVERHAUL. 3953	M		
	230	REASSEMBLE .	M		
	240	VACUUM DRY IGN EXCITER FOR PERIOD OF 4 HRS AT 170 DEG F AT ONE INCH MER CURY ABSOLUTE PRESS MAX.	M		
	250	FILL CAPACITOR ASSEMBLY COMPARTMENT WITH RESIN.	M		
	260	BAKE IGNITION EXCITER AS FOLLOWS: 200 DEG F/1 HR. 240 DEG F/1 HR. 300 DEF F/2 HRS.	M		
[illegible]-35	270 MTPIW	MOVE TO WELDING SHOP & WELD LID TO EXCITER & PERFORM LEAK TEST.	M	(2 hrs)	
	300	CLOSE VACUUM LINE & PRESSURIZE IGN ITION EXCITER TO 15 PSI GAGE WITH DRY AIR OR NITROGEN HAVING A DEW	M		

(CONTINUED)

15.DISP-16.FDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		POINT OF 65 DEG F. OR BELOW			
W-41	310 MIPIA	PAINT REQ_____________ NOT REQ___________	M		
WW-41	320 MIPIA	PAINT IGNITION EXCITER. APPLY LACQUER, FED SPEC TT-L-32, TO A FILM THICKNESS OF ACT_____________INCH	M		
	330 MIPIA	ALLOW TO DRY FOR 40 MINUTES IN DUST-FREE ATMOSPHERE. IF PAINT BLISTERS, STRIP POROUS AREA. CLEAN & REPAINT.	M		
	340	TEST: CHECK CONTINUITY BETWEEN TWO OUTPUT TERMINALS OF IGN. EXCITER. *OHMMETER*	M		
	350	TEST: APPLIED VOLTAGE (VDC) 14.0 INPUT CURRENT SPARK RATE (PER SECOND) OUTPUT VOLTAGE (VOLTS) ACT____________VOLTS ACT____________AMPS ACT____________S/R APPLIED VOLTAGE 24 INPUT CURRENT SPARK RATE OUTPUT VOLTAGE ACT:______________AMPS MAX ACT:______________S/R ACT:______________VOLTS APPLIED VOLTAGE 30 INPUT CURRENT SPARK RATE OUTPUT VOLTAGE ACT_______________VDC ACT:______________VOLTS ACT:______________AMPS MAX. ACT:______________S/R	M 3906 or 4789		
	360	AFTO 349 COMPLETE & FORWARDED TO DATA AUTOMATION.	M		
	370	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M		
	380	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M		

CAEC07 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89045

15.DISP-STATION	16.PDN/OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	385	COMPLY WITH MAOI 66-36, PARA 13			
			M		
		TYPE WORK PERFORMED________________			

CAEZ05 * WORK CONTROL DOCUMENT * JC   1.DATE 88204 PAGE 1 OF 3 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
		MTPCAP	89094	

7.. ART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
		8E1 8-22-3 8/26/H CHG 16

10.MODEL/DESIGN/SERIES | 11.STOCK NR
H 41 A1/402D

13.N... ...NOUN/END ITEM NOUN
IGNITION EXCITER   FAC

WENDEL HAWKINS

WOLFTRUM/MATEAC/60720

P/N	NSN	C/N
10-387790-3	2925010776866UL	6120.1A
10-387990-3	2925010776866UN	49.20A
6896127	2925010776866UN	50070A

16.DAT... 16.I DR/
STATION/OP NO. | 17.WORK TO BE ACCOMPLISHED | 18.RESULTS/ INITIALS

NOTE:
EXCITERS 6892666, 6896173, 6896129, ARE WORKED THE SAME EXCEPT AS NOTED IN DIFFERENCE DATA SHEETS LOCATED IN T.O.

005 | COMPLETE AF FORM 1534 IAW AFM 400 1, VOL II/DC-ALC TAB B SW 1 | 1 M

010 | RECEIVE, IDENTIFY & ATTACH PAPERWORK | 1 M

015 | ALL REFERENCES ARE TO THE BASIC T.O. ... APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE. | M

020 | TEST EXCITER: APPLIED VOLTAGE (VAC) 19, INPUT FREQUENCY (HERTZ)-400, INPUT CURRENT (AMPS MAX) -3, SPARK RATE (SPARK PER MIN) OUTPUT VOLTAGE (VOLTS) | M

SIDE #1
AMPS____________________
SPARK RATE______________   Test equip ?
OUTPUT VOLTAGE__________   6c 3906

oc ← volt-current meas.

SIDE #2
AMPS____________________
SPARK RATE______________
OUTPUT VOLTAGE__________

030 | AN EXCITER FAILING ANY TEST SHOULD BE DISASSEMBLED ONLY TO THE EXTENT REQUIRED TO LOCATE AND CORRECT CAUSES OF MALFUNCTION AND LIMITED AS REQUIRED TO ACCOMPLISH MECHANICAL | M

(CONTINUED)

CAEZOS * WORK CONTROL DOCUMENT * JC		1.DATE 00204	PAGE 2 OF 3 PAGES		
15.DISP	16.PDN/				
STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		AND/OR ELECTRICAL REPAIR.			
	040	DISASSEMBLE.	45 M		
	050	CLEAN AS REQUIRED.	M		
	060	INSPECT.	M		
	070	CHECK COMPONENTS PARTS AS NECESSARY	Test equip? 3952 M	OC	OC
	200	REPAIR OR REPLACE AS NECESSARY.	M		
	206	IF REQUIRED: ROUTE HOUSING P/N 10 303741 & COVER P/N 10-301301 FOR PLATING. REQ__________ NOT REQ__________	M		
	201	ENSURE DEPTH OF CONTACT HEAD IN INSULATOR SHELL (10) TO 0.375. . ACTUAL__________INCH	M		
	202	APPLY AN EVEN COATING OF RTV SILI CONE RUBBER ADHESIVE. ALLOW ASSEM- BLY TO CURE FOR 24 HRS MIN AT ROOM TEMP.	M		
	270	REASSEMBLE.	M		
	275	SOLDER EXCITER.	M		
	310	PRESSURIZE EXCITER WITH 15 PSI NITROGEN. SUBMERGE EXCITER IN WATER HEATED TO A MINIMUM OF 1.. ... WITH SUFFICIENT AMOUNT OF WETTING AGENT. FOR MINIMUM OF 1 MINUTE.	M		
	370	CLOSE OVEN AND HEAT IGNITION EXCITER TO 210 DEGF TO 230 DEG F FOR 1/2 HR.	M		
	380	EVACUATE IGNITON EXCITER TO 1 INCH MERCURY & CONTINUE BAKING FOR 4 TO 12 HRS MINIMUM.	M		
	390	CLOSE VACUUM LINE & PRESSURIZE IGNI- TION EXCITER TO 15 PSIG WITH DRY AIR OR NITROGEN HAVING A DEW POINT OF -65 DEG F.	M		
	400	REMOVE IGNITION EXCITER WITH STOP- COCK FROM OVEN & ALLOW TO COOL TO	M		

(CONTINUED)

CAEZ05 * WORK CONTROL DOCUMENT * [illegible] 1. DATE 88204 PAGE 3 OF [illegible]

15. DISP-16. PDN/

STATION	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19 "P"	20 "Q"
		ROOM TEMP			
	410	SEAL PLUG & IMMERSE EXCITER IN WATER MAINTAINED AT A TEMPERATURE OF 100 TO 200 DEG. F. FOR 1 MINUTE.	M		
	420	TEST EXCITER: APPLIED VOLTAGE (VAC) -19, INPUT FREQUENCY (HERTZ) - 400, INPUT CURRENT (AMPS MAX) - 3, SPARK RATE (SPARK PER MIN) OUTPUT VOLTAGE (VOLTS) SIDE #1 AMPS____________ SPARK RATE____________ OUTPUT VOLTAGE____________ SIDE #2 AMPS____________ SPARK RATE____________ OUTPUT VOLTAGE____________	M		
R [illegible]	425 MAINPA	PAINT	M		
	430	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION	M		
	440	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M		
	450	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M		
	460	NAVY FORM OPNAV 4790/113 OR AF FORM AFTO 95 FILLED OUT COMPLETELY AND STAPLED TO SERVICEABLE TAG.	M		
	405	COMPLY WITH MA01 66-36, PARA 13 TYPE WORK PERFORMED______________	M		
	470	COMPLETE AF FORM 1534 AND AFTO FORM 205 (IF APPLICABLE) AND ANNOTATE TSO/ION ON THE AF FORM 1574 SERVICEABLE TAG IAW AFM 400 1 VOL II/OC-ALC TAFB SUP 1.	M		

NUMBER [illegible] 19.1 [illegible]

[illegible]ION/SERIES [illegible]

	30
040	[illegible]VE TO MACHINE
045	DISASSEMBLE
055	INSPECT AS [illegible]
[illegible]	TEST [illegible] ASSEMBLE

ACT

RESISTANCE 1

1

2

5

45

24

dry N_2

oven

CLEAR CHECK [illegible]
(USING THE [illegible]

CAEC05 * WORK CONTROL DOCUMENT * JC   1.DATE 89045   PAGE 1 OF 7 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
[redacted] 61234		MTPCAP	89121	

7.PART NUMBER: 41540 (M)

9.ITEM SERIAL NR:

8/12.TECH DATA/OPTIONAL:
PO MAT87-3
PO MAT87-16
8E1-8-9-3   86135H
CHG 10
8E1-8-9-3-1   78152H
CHG 3

10.MODEL/DESIGN/SERIES: TF33-5/9

11.STOCK NR: 2925004637319KV

13.MISC

14.NOUN/END ITEM NOUN: IGNITION EXCITER   PAC

JENNINGS/MATEAC/65920

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		61234A 2925-01-011-2325KV 42721 (TF33 P5/7)			
		NOTE MODIFY ABOVE P/N EXCITER ASSEMBLIES IAW T.O. 8E1-8-9-3-1 (OVERHAUL CONFIGURATION CHANGE DATA)			
W-43	010	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE. Transformer change	M		4.5hrs
	030	~~CLEAN AS REQUIRED.~~	M		
	040	INSPECT AS REQUIRED.	M		
	~~045~~	~~ROUTE COVER/CASE TO PLATING AS REQ.~~	M		
Initial	050	CAPACITOR TEST: TRIGGER CAPACITOR, APPLY 5000VDC BETWEEN CAPACITOR TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS. LEAKAGE. . ACTUAL MICROAMP. *CAPACITOR BRIDGE TESTER	M		
	060	CHECK CAPACITANCE. . ACTUAL UF	M		
	070	TEST BREAKER CAPACITOR BY APPLYING 600VDC BETWN TERMINAL & GROUND FOR NOT MORE THAN 30 SECONDS. .	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		ACTUAL MICROAMP			
	080	CHECK CAPACITANCE. . ACTUAL UF	M		
	090	TEST 3 STORAGE CAPACITORS AS A CONNECTED GROUP. APPLY 4000VDC BETWN FREE END ON INTER-CONNECT LEAD & GROUND ON CASE. LEAKAGE . ACTUAL MICROAMP	M		
	100	CHECK CAPACITANCE AT SAME TERMINAL . . ACTUAL UF	M		
	110	FILTER TEST: APPLY 300 VDC BETWN "B" PIN & GROUND FOR NO MORE THAN 30 SEC THERE MUST BE NO SIGN OF BREAKDOWN.	M		
	120	CHECK LEAKAGE BETWEEN EITHER TERMINAL AND CASE: . ACTUAL MEGOHMS *VACUUMTUBE VOLTMETER	M		
	130	CAPACITANCE. . ACTUAL UF *CAPACITOR BRIDGE TESTER	M		
	140	RESISTOR TEST (29): MEASURE RESISTANCE BETWN UPPER TERMINAL OF RESISTOR LEAD & CASE. . ACTUAL OHMS *VACUUMTUBE VOLTMETER	M		
	150	TEST EACH RESISTOR INDIVIDUALLY. . ACTUAL OHMS . ACTUAL OHMS	M		
	160	TEST RESISTOR ASSY (45) MEASURE RESISTANCE BETWEEN RESISTOR LEADS. . . ACTUAL MEGOHMS	M		
	170	TEST EACH RESISTOR INDIVIDUALLY; MEASURE RESISTANCE BETWN RESISTOR TERMINALS.	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		. ACTUAL MEGOHMS			
	180	RECTIFIER TEST: USE HIGH VOLTAGE REGULATOR TO ADJUST VOLTAGE TO 5000V READ INVERSE VOLTAGE CURRENT. . ACTUAL MEGOHMS *TEST FIXTURE	M		
	190	RAISE VOLTAGE UNTIL MILLIAMMETER SHOWS READING OF 100MA. FORWARD VOLTAGE DROP ACROSS RECTIFIER. . ACTUAL VOLTS *DC VOLTAGE REGULATOR	M		
	195	VIBRATOR OVERHAUL: COIL TEST: MEASURE RESISTANCE BETWEEN SECONDARY OUTPUT TERMINAL & GROUND. ACT: OHMS *VACUUMTUBE VOLTMETER	M		
	200	VIBRATOR TEST: INTERMEDIATE VOLTAGE 2400 SPARK RATE. ACTUAL SPM INTERMEDIATE VOLTAGE 2500 SPARK RATE ACTUAL SPM INTERMEDIATE VOLTAGE 2600 SPARK RATE ACTUAL SPM INTERMEDIATE VOLTAGE 2700 SPARK RATE ACTUAL SPM *VOLTASCOPE	M		
	210	PRIMARY WAVE FORM FOR AN INPUT RANGE MUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS. ACT VOLTS . ACTUAL AMP ACTUAL AMP *VOLTAGE REGULATOR	M		
	220	PRIMARY WAVE FORM FOR AN INPUT RANGE MUST NOT EXCEED AMP & VARIATIONS BETWN PEAKS.	M		

(CONTINUED)

CAECOS * WORK CONTROL DOCUMENT * JC 1.DATE 89045

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		ACT VOLTS ACTUAL AMP ACTUAL AMP			
	230	DISCHARGER TUBE TEST: RAISE VOLTAGE SOURCE SLOWLY TO MAX OF 5000V. IF TUBE BREAKS DOWN AT LEVEL BELOW 4100 VOLTS, REPLACE. IF IT BREAKS DOWN BETWN 4100 & 5000V, OR IF IT DOES NOT BREAK DOWN AT ALL, IT IS A GOOD TUBE. REPLACED NOT REPLACED *TEST FIXTURE	M		
	240	READ VOLTAGE OVER A PERIOD OF 30 SECONDS. ACTUAL VOLTS	M		
	250	HIGH TENSION TRANSFORMER TEST: CHECK RESISTANCE BETWN THE 2 TERMINALS TO WHICH PRIMARY LEADS ARE ATTACHED. ACTUAL OHM *OHMMETER	M		
	260	ADJUST FOR GAP & INTERNAL PRESSURE. ACTUAL INCH ACTUAL PSIG *IGNITION OUTPUT TESTER	M		
	270	REPAIR OR REPLACE AS NECESSARY.	M		
	280	TO CLINCH KNURLED FLANGE TO CASE, TORQUE A NUT AGAINST OUTER WALL OF CASE. ACTUAL IN/LB *TORQUE WRENCH.	M		
	300	ALL SCREWS & LOCKNUTS SHOULD BE TORQUED. ACTUAL IN/LB *TORQUE WRENCH	M		
	310	TEST IAW T.O. 8E1-3-7-3, PARA 2-36 SUB PARA "A" *TEST FIXTURE	M		
	340	RAISE TRANSIFIER VOLTAGE REGULATOR UNTIL WAVE FORM DISPLAYED ON VOLTA-SCOPE SHOWS FIRST PEAK. ACTUAL VOLTS	M		

15.DISP-16.FDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	350	THE FIRST HALF CYCLE SHOULD BE NEGATIVE & MUST SHOW AT LEAST 2 POSITIVE PEAKS & 2 NEGATIVE PEAKS WITHIN THE PERIOD OF 1 MILLISECOND. *TEST FIXTURE	M		
	360	REASSEMBLE.	M		
	370	TEST STORAGE CAPACITOR; RAISE INPUT VOLTAGE TO 14V FOR NO MORE THAN 10 SECONDS. VALUE ACTUAL VOLT *VOLTASCOPE	M		
	380	TEST: INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL SR INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL SR INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL SR	M		
	390	TIGHTEN HEX NUTS AT INPUT END, LARGE NUT SHOULD BE TORQUED & THE 2 SMALLER NUTS. ACTUAL AMP ACTUAL IN/LB *TORQUE WRENCH	M		
	400	SOLDER UNIT.	M		
	410	TEST EXCITER FOR LEAKS USING A PROBE WITH 14 PSIG. LEAKAGE. ACTUAL CC *VEECO LEAK DETECTOR	M		
	420	SUBMERGE EXCITER IN WATER HEATED TO MINIMUM OF 49 DEG C (120 DEG F) FOR	M		

(CONTINUED)

CAECOS * WORK CONTROL DOCUMENT * JC 1.DATE 89045

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		1 MINUTE.			
	430	GAS CHARGING: BAKE EXCITER 15 MIN. AT 275 DEG F. THEN TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR ADDITIONAL 15 MINUTES.	M [illegible]	[illegible]	
W-41	440	PAINT.	M		
	450	BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F. OR AIR DRY. .	M		
	460	TEST: SET MICROMETER UNTIL SCALE READING INDICATES SPARK GAP OF 0.100 INCH. ADJUST NITROGEN INLET UNTIL GAGE HOLDS STEADY. ACTUAL PSIG *IGNITION OUTPUT TESTER	M		
	470	TEST: INPUT VOLTAGE 14 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 24 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL PER 10 SEC INPUT VOLTAGE 29 INPUT CURRENT SPARK RATE ACTUAL AMP ACTUAL PER 10 SEC	M		
	490	APPLY 24V INPUT CURRENT. OBTAIN ONE (1) OF THE FOLLOWING: METER READING 72.5 78.0 83.0 87.5 91.5 ACTUAL	M		

CAECO5 * WORK CONTROL DOCUMENT * JC 1.DATE 89045 PAGE 7 OF 7 PAGES

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	500	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	545	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO, CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M		
	546	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED	M		
	550	OPERATIONS COMPLETED & PAPERWORK PROCESSED.	M		

CAEBOS * WORK CONTROL DOCUMENT * JC	1.DATE 89033	PAGE 1 OF 4 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
97133A		MTPCAJ	89131	

7.PART NUMBER	9.ITEM SERIAL NR	8/12.TECH DATA/OPTIONAL
AV11A1134		PO MAT87-3 6J15-9-19-3 84245H CHG 1

10.MODEL/DESIGN/SERIES	11.STOCK NR
J-57	4810002041575RV

13.MISC	14.NOUN/END ITEM NOUN
	ELECTROMAG 3 WAY SELECT VLVPAC JENNINGS/MATLAC/65920

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
W 43	010	RECEIVE, IDENTIFY AND ATTACH PAPERWORK.	M		
	015	ALL REFERENCES ARE TO THE BASIC T.O. & APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS & TOLERANCES REQUIRING COMPLIANCE.	M		
	020	DISASSEMBLE.	M		
	030	CLEAN AS REQUIRED.	M		
	040	INSPECT.	M		
	045	INSPECT SPRINGS FOR CRACKS USING FED SPEC MIL-I-6868A.	M		
	~~050~~	~~INSPECT SPRING (12)~~ O.D. ACT: INCH HEIGHT ACT: INCH LOAD ACT: LBS COMPRESSED. HEIGHT ACT: INCH LOAD ACT: LBS	M		
	~~060~~	~~INSPECT SPRING~~ (5). O.D. ~~ACT: INCH~~ WORKING HEIGHT ACT: INCH LOAD ACT: LBS ~~COMPRESSED.~~ ~~HEIGHT~~ ACT: INCH	M		

(CONTINUED)

CAEBOB * WORK CONTROL DOCUMENT * JC   1.DATE 87033

15.DISP STATION	16.PDN/ OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		LOAD ACT: LBS			
	070	TEST ELECTROMAGNET COIL: APPLY 1000 VOLTS RMS, FOR ONE MINUTE. LEAKAGE ACT MA NO BREAKDOWN OF DIELECTRIC STRENGTH	M		
	080	REPAIR OR REPLACE AS NECESSARY.	M		
	090	ROUTE BODY P/N 1043258 TO ~~MIPCM~~ BLDG 3001, POST P-39 FOR MACHINING. MATPCM	M		
	100	REASSEMBLE.	M		
	110	MEASURE DISTANCE FROM UPPER SURFACE OF ARMATURE TO BODY UPPER LAND SURFACE . P/N ACT IN	M		
	120	REQUIRED SPRING (5) WEIGHT . ACT: LBS	M		
	130	DISTANCE BETWEEN ARMATURE TOP SURFACE AND BODY UPPER LAND SUR-FACE ACT: INCH	M		
	140	TORQUE SCREW (1) . ACT: IN/LBS	M		
	150	MEASURE DISTANCE FROM LOWER END OF BODY SHOULDER TO BOTTOM OF SPRING RECESS IN LOWER NEEDLE WITH PIN INSTALLED. ACT: INCH	M		
	160	MEASURE DISTANCE FROM KNIFE EDGE OF CAP TO TOP OF CAP THREAD SHOULDER . ACT: INCH	M		
	170	MEASURE DISTANCE FROM TOP OF CAP THREAD SHOULDER TO BOTTOM OF SPRING RECESS IN INSIDE OF CAP. ACT: INCH	M		
	180	COMPRESSED LENGTH OF LOWER SPRING.	M		

(CONTINUED)

15.DISP- 16.PDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		ACT:			
	190	ASSEMBLE LOWER SPRING (12), CHECK WEIGHT ACT: LBS	M		
	200	TORQUE CAP (10) ACT: FT/LBS	M		
	210	TEST: FLOW REQUIREMENTS - APPLY 200 PSIG MAXIMUM PRESSURE DROP + 75 DEG F. .	M		
	220	SOLENOID DE-ENERGIZED, APPLY FLUID PORT (3). FLOW PORT (2) . ACT: GPM	M		
	230	SOLENOID ENERGIZED WITH 18 +/- 1 VOLT DC. APPLY FLUID PORT (1). FLOW PORT (2) ACT: VDC ACT: GPM	M		
	240	LEAKAGE TEST: APPLY 50 PSIG TO PRESSURE PORT. LEAKAGE AT WEEP PORT . ACT:	M		
	250	APPLY 18 PSIG TO WEEP PORT. LEAKAGE AT TANK PORT . ACT:	M		
	260	APPLY 18 +/- 1 VOLT DC TO SOLENOID. APPLY 50 PSIG TO WEEP PORT. LEAKAGE AT TANK PORT . ACT:	M		
	270	APPLY 50 PSIG TO WEEP AND TANK PORTS. NO EXTERNAL LEAKAGE ALLOWED.	M		
	280	OPERATION TEST: APPLY 50 PSIG TO PRESSURE PORT. APPLY 18 +/- 1 VOLT DC TO SOLENOID. VALVE SHALL FLOW THE APPLIED TEST FLUID. ACT:	M		

(CONTINUED)

15.DISP-16.PDN/ STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		ACT:			
	290	AFTO FORM 349 COMPLETED AND FOR-WARDED TO DATA AUTOMATION.	M		
	300	SAFETY WIRE	M		
	310	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS, SUPPLEMENTS & APPLICABLE PROCESS ORDERS.	M		
	320	OPERATIONS COMPLETE AND PAPERWORK PROCESSED	M		
	325	COMPLY WITH MAOI 66-33, PARA 13 TYPE WORK PERFORMED	M		

CATION & WORK ORDER DOCUMENT [illegible]

ORDER/CARD NO | QUANTITY | PROD. ACCOUNT | DATE [illegible]

MUTAP

PART NUMBER | 19. ITEM SERIAL NO. | [illegible]

[illegible] /SER [illegible]

[illegible]

This is the same as 49711A

Replace the gap tube which contain Cesium 137 with Krypton (Kr) 85. Reduces Radioactive ~~level~~ exposure to employee.

[illegible] | DISASSEMBLE

CLEAN [illegible]

INSPECT

051 | INSPECT HOUSING [illegible]

ACT [illegible]

REPLACED NEW [illegible]

REPAIR REQ [illegible]

[illegible] | MARK UNDERSIZE HOUSINGS [illegible] WELDING [illegible]

060 | MEASURE [illegible]

[illegible] INPUT [illegible] & OUTPUT LEAD.

ACTUAL [illegible]

[illegible]

070 | WELD [illegible]

(CONTINUED)

[illegible] CONTROL DOCUMENT [illegible] (DATE [illegible])

SEQUENCE NO	PROCEDURE TO BE ACCOMPLISHED	[illegible]
	REQ: [illegible]	
030	MEASURE CAPACITANCE [illegible] PIN & HSG. ACT [illegible]	[illegible]
[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]
[illegible]	MEASURE [illegible]ARY RESISTANCE [illegible] TRANSFORMER [illegible] ACT [illegible]	[illegible]
[illegible]	[illegible]	[illegible]
[illegible]	[illegible]	[illegible]
[illegible]	CAPACITANCE [illegible] GROUND ACT [illegible]	[illegible]
[illegible]	CAPACITANCE [illegible] ACT [illegible]	[illegible]
140	CAPACITANCE [illegible] ACT [illegible]	[illegible]
[illegible]	APPLIED VOLTAGE [illegible] NO 1 LEAD & GROUND ACT [illegible] APPLIED VOLTAGE [illegible] NO 2 LEAD & GROUND ACT VDC APPLIED VOLTAGE [illegible] LEAD ACT [illegible] APPLIED VOLTAGE [illegible] LEAD ACT VDC	[illegible]

(CONTINUED)

WORK CONTROL DOCUMENT [illegible] PAGE [illegible]

OP NO. | WORK TO BE ACCOMPLISHED [illegible]

	OP NO.	WORK TO BE ACCOMPLISHED				
		THERE SHALL [illegible] NO [illegible] FLASHOVER OF ANY SECTION DURING [illegible] SECOND PERIOD [illegible] JET IGNITION [illegible]				
	180	MEASURE RESISTANCE [illegible] RESISTORS [illegible] RESISTANCE [illegible]	M			
	[illegible]	[illegible]	M			
	[illegible]	[illegible]				
	[illegible]	[illegible]	M			
	[illegible]	[illegible] OPERATOR SHALL BE [illegible] AT EACH [illegible]	M			
	[illegible]	[illegible]	M			
	240	VACUUM DRY [illegible] EXCITER [illegible] HRS AT 190 [illegible] CURY ABSOLUTE PRESSURE	M			
	250	FILL CAPACITOR [illegible] WITH RESIN.	M			
	260	BAKE IGNITION EXCITER AS FOLLOWS: 200 DEG F/1 HR; 240 DEG F/1 HR; 300 DEG F/2 HRS	M			
	[illegible]	MOVE TO [illegible] EXCITER & PERFORM LEAK TEST	M			
	290	CLOSE VACUUM LINE & PRESSURIZE [illegible] EXCITER [illegible] DRY AIR OR NITROGEN HAVING A DEW	M			

(CONTINUED)

WORK CONTROL DOCUMENT [illegible]

DATA CONTROL NO	OP NO	WORK TO BE ACCOMPLISHED	[illegible]			
		POINT OF [illegible]				
[illegible]	310 MIPIA	PAINT				
		RED [illegible]				
[illegible]	[illegible] MIPIA	PAINT CONDITION [illegible] [illegible] [illegible] [illegible]	[illegible]			
	[illegible]	[illegible]	[illegible]			
	[illegible]	[illegible]	[illegible]			
	[illegible]	[illegible]				
	[illegible]	[illegible] SPARK RATE [illegible] ACT: [illegible] ACT: [illegible] ACT: [illegible] ACT: [illegible]				
	360	AFTO 349 COMPLETED & FORWARDED TO DATA [illegible]	M			
	370	I CERTIFY THAT THIS [illegible] HAS BEEN OVERHAULED [illegible] CURRENT REVISIONS, SUPPLEMENTS AND APPLICABLE PROCESS ORDERS.	M			
	380	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M			

CALCO7 & WORK CONTROL DOCUMENT [illegible]

[illegible] 16 EDN7

STATION NO. 117,WORK TO BE ACCOMPLISHED [illegible]

	303	COMPLY WITH [illegible]				
		TYPE WORK [illegible]				

CAEC11 * WORK CONTROL DOCUMENT * 72-10 1.DATE 89045 PAGE 1 OF 6 PAGES

2.ORIG/PROD NR	3.QUANTITY	4.PROD SECTION/RCC	5.DATE SCHED	6.DATE COMP
98093A		MTPCAP	89094	

7. PART NUMBER: 46317 (M)
9. ITEM SERIAL NR:
8/12. TECH DATA/OPTIONAL: PO MAT87-3 / 8E1-8-8-3 ENG ~~HOT~~ INST 87074H / CHG 21 / 8E1-8-8-8-1 80007H / CHG 3

10. MODEL/DESIGN/SERIES: TF33-7
11. STOCK NR: 2925004567627RV

13. MISC / 14. NOUN/END ITEM NOUN: IGNITION EXCITER PACI TO
ENGS/MATEAC/65920 520

15. DISP-16. PDN/

STATION	OP NO.	17. WORK TO BE ACCOMPLISHED	18. MECH	19"P"	20"Q"
W-43 ✓	~~010~~ 520	RECEIVE, IDENTIFY & ATTACH PAPERWORK	M		
✓	015 525	ALL REFERENCES ARE TO THE BASIC T.O. AND APPLICABLE PROCESS ORDERS. TECH DATA CONTAINS DETAILED NOTES, CAUTIONS, WARNINGS, DIMENSIONS AND TOLERANCES REQUIRING COMPLIANCE.	M		
✓	~~020~~ 525	DISASSEMBLE. (~~AM 3~~	M		
DELETE	025	REPAIR CASE ASSY. REQ.__________ NOT REQ.__________	M		
✓	030 530	CLEAN AS REQUIRED. (DO NOT WIPE OR BRUSH AWAY THE EXCESS SOLDER & DO NOT DAMAGE SOLDER COATING)	M		
✓	040	INSPECT AS REQUIRED.	M		
✓	060 540	CAPACITOR TEST: TEST SMALLER MULTIPLE CAPACITOR. GROUND "B" TERMINAL TO CASE. APPLY 5000VDC BETWEEN TERMINALS C, D & E AND CASE FOR NOT MORE THAN 30 SECONDS. ACTUAL C.__________ *TEST CONSOLE D.__________ E.__________	M		
✓	560	APPLY 5000VDC BETWEEN TERMINALS "A" & "B" FOR NOT MORE THAN 30 SECONDS. ACT:__________ REMOVE GROUND FROM "B" TERMINAL.			
	560	SHRT "B" TERMINAL TO "A" TERMINAL & APPLY 5000VDC BETWEEN TERMINALS "A" & "B" & THE CASE FOR NOT MORE THAN 30 SECONDS. ACT:__________			
	570	CHECK CAPACITANCE BETWEEN TERMINALS: A TO B__________ ACT:__________ B TO C__________ ACT:__________ C TO CASE__________ ACT:__________ D TO CASE__________ ACT:__________			

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		E TO CASE________ACT:____________ *CAPACITOR BRIDGE TESTER			
	~~100~~ OP 060	TEST LARGER MULTIPLE CAPACITOR BY APPLYING 5000VDC BETWEEN TERMINALS "A" & "C" FOR NOT MORE THAN 30 SEC. ACTUAL______________ *TEST CONSOLE WHILE SHORTING TERMINALS "A" & "C" TOGETHER, APPLY 5000VDC BETWEEN TERMINALS "B" & "C" FOR NOT MORE THAN 30 SECONDS. ACT:______________ SHORT TERMINALS "A", "B" & "C" TOGETHER & APPLY 5000VDC BETWEEN TERMINALS & CASE. ACT:______________ CHECK CAPACITANCE FROM TERMINAL "A" TO "C" & FROM TERMINALS "C" TO "B" ACT:____________A TO C ACT:____________C TO B *CAPACITOR BRIDGE TESTER	M		
	160 070	FILTER TEST: APPLY 400VDC BETWEEN LONGER OUTPUT TERMINAL & GROUND, WHILE "C" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN. *TEST CONSOLE APPLY 600VDC BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE "B" PIN IS GROUNDED. THERE MUST BE NO SIGN OF BREAKDOWN. CHECK LEAKAGE BETWEEN SHORTER OUTPUT TERMINAL & GROUND, WHILE "B" PIN IS GROUNDED; THEN CHECK LEAKAGE BETWEEN LONGER OUTPUT TERMINAL & GROUND WHILE "C" PIN IS GROUNDED. ACT:___________ACT:______________ *VACUUMTUBE VOLTMETER MEASURE CAPACITANCE BETWEEN SHORTER OUTPUT TERMINAL & GROUND ACT:________________ *CAPACITOR BRIDGE TESTER BETWEEN LONGER FILTER OUTPUT TERMINAL & GROUND ACT:________________	M		
080	210	RESISTOR TEST: RESISTORS (6) (6) ACTUAL__________ *VACUUM TUBE VOLTMETER 325	M		
	220	RESISTOR (5) ACTUAL__________	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		RESISTOR (10) ACTUAL________________			
	270 +	AC RECT. TEST: ADJUST VOLTAGE TO 4000V & READ INVERSE VOLTAGE CURRENT ON SAME METER BY PUSHING BUTTON MARKED "500UA". . 3952 ACTUAL________________ *VOLTAGE REGULATOR RAISE VOLTAGE UNTIL MILLIAMETER SHOWS A READING OF 100MA. READ VOLTAGE DROP ACROSS RECTIFIER ACT____________________	6m M		
	~~290~~ 090	TUBE P/N 85944 DISCHARGER TUBE TEST: ALLOW DISCHARGER TUBE TO FIRE FOR 4 MINUTES, THEN DURING SUCCEEDING 1 MINUTE PERIOD OBSERVE BREAKDOWN VOLTAGE. . . ACTUAL ___________ *TEST CONSOLE	M		
	~~300~~ 090	TUBE P/N 24222: ADJUST HIGH VOLTAGE REGULATOR UNTIL TUBE IS FIRING AT A RATE OF 1 SPARK PER SECOND; THEN DURING THE SUCCEEDING 30 SECOND PERIOD OBSERVE THE BREAKDOWN VOLTAGE. . ACTUAL________________	M		
	~~310~~ 090	TUBE P/N 24498: VALUE OF BREAKDOWN VOLTAGE OF TUBE UNDER TEST OVER A PERIOD OF 1 MINUTE . ACTUAL_________ ACTUAL_________	M		
	~~320~~ 100	FEED-THRU TERMINAL TEST: APPLY 5000V DC BETWEEN TERMINAL & CASE, LEAKAGE . ACTUAL_________	M		
	330	HIGH TENSION TRANSFORMER TEST: SET UP IGNITION OUTPUT TESTER & ADJUST FOR GAP OF 0.200 IN & INTERNAL PRESSURE OF 20 PSIG. . OC 3953	M		

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	350	SMALL TRANSF TEST: CHECK CONTINUITY BETWEEN "C" & "A" LEADS AND BETWEEN "C" & "B" LEADS.	M	6 MINS	
	~~360~~ 110	POWER TRANSF TEST: APPLY 80V, 400 CYCLE AC, BETWEEN PRIMARY TERMINAL & GROUND. READ EXCITING CURRENT ACTUAL__________ SHORT SECONDARY TERMINALS TOGETHER & APPLY 2000 VDC BETWEEN PRIMARY & SECONDARY TERMINALS FOR 30 SECONDS. THERE MUST BE NO EVIDENCE OF ELECTRICAL BREAKDOWN.	M		
	~~380~~ 120	IAW CHOPPER TEST (PER T.O. PG 4-17)	M		
	~~400~~ 380	REPAIR OR REPLACE AS NECESSARY.	M		
	415	HIGH TENSION TRANSF RAISE PRESSURE TO 25PSIG & SUBMERGE UNIT IN WATER. LEAK CHECK FOR BUBBLES. SOLDER BENCH	M 12 M		
	450	REMOVE ADAPTER & BAKE ASSY IN OVEN 2 HRS AT A TEMP OF 250 DEG F TO REMOVE ALL TRACES OF MOISTURE.	M 6H	2 HR FLOW	
	~~480~~ 370	REASSEMBLE.	M		
	~~490~~ 390	LAY A NEW GROUNDING BRAID (14) IN GROOVE IN CAP (13), MAKING CERTAIN IT LIES DEEP IN GROOVE TO PREVENT FRAYING OR PINCHING WHEN CAP IS SCREWED ON. TORQUE CAP ACTUAL__________ *TORQUE WRENCH	M		
	~~500~~ 460	INTERMEDIATE TEST: STORAGE CAPACITOR: TEST HIGH VOLTAGE LEAD ON "A" TERMINAL OF LARGER MULTIPLE CAPACITOR, RAISE INPUT VOLTAGE TO 14V FOR NOT MORE THAN 10 SECONDS. ACTUAL__________ *TEST CONSOLE APPLY INPUT VOLTAGE SUCCESSIVELY AT 14,24, & 29 V. AT A RATE OF NOT LESS THAN 5.0 SPARKS OVER A 10-SEC PERIOD & READ INPUT CURRENT ON TEST CONSOLE (14) ACT______S/R ACT_______AMPS (24) ACT______S/R ACT_______AMPS (29) ACT______S/R ACT_______AMPS READ STORAGE CAPACITOR VOLTAGE ON	M		

(CONTINUED)

15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
		VOLTASCOPE ACT:____________VOLTS READ INPUT CURRENT & SPARK RATE IN WINDOW OF OUTPUT TESTER CONNECTED TO LEFT OUTPUT. ACT:__________ AMPS ACT:__________S/R			
	~~540~~ 520	PREPARE UNIT FOR FILLING WITH POTTING COMPOUND BY PRE-BAKING FOR AT LEAST 1 HR AT 300 DEG F.	M		
	~~550~~ 520	BAKE EXCITER IN CIRCULATING AIR OVEN AT LEAST 2 HRS AT TEMP OF 225 DEG F. RAISE TEMP TO 300 DEG F CURE 4 HRS. .	M		
	~~560~~ 525	SOLDER & TORQUE FILTER ATTACHING JAM NUT ACTUAL__________ IN/LBS *TORQUE WRENCH	M		
	~~565~~ 525	WHILE APPLYING HEAT TO FLOW SOLDER, TORQUE SLOWLY. FILL SLOTS IN SCREW HEADS WITH SOLDER 6-32 ACT__________ 8-32 ACT__________ *TORQUE WRENCH	M		
	~~570~~ 530	PRESSURE TEST: TEST FOR LEAKS USING PROBE WITH 15 PSIG IN EXCITER WITH HELIUM. (ALT LEAK CHECK IN WATER) . ACTUAL__________ *VEECO LEAK DETECTOR	M		
	~~580~~ 540	GAS CHARGING: SET THERMOSTAT AT 290 DEG F; BAKE EXCITER 15 MIN AT THIS TEMP. TURN ON VACUUM PUMP SWITCH & EXHAUST EXCITER WHILE CONTINUING TO BAKE FOR AN ADDITIONAL 15 MINUTE. . *GAS CHARGING FIXTURE	M		
W-41	560 ~~590~~ MTPCA	MOVE EXCITER TO PAINT SHOP.	M		
	~~595~~ 560	PAINT BAKE IN OVEN FOR 1 HR AT A TEMP OF 250 DEG F.	M		
	~~610~~ 570	FINAL TEST RAISE INPUT VOLTAGE TO 24V. RAD INPUT CURRENT & METER READING ON TESTER	M		

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15.DISP-16.PDN/

STATION	OP NO.	17.WORK TO BE ACCOMPLISHED	18.MECH	19"P"	20"Q"
	570 REF	ACT:____________ACT______________ *TEST CONSOLE PUSH "COUNTER RESET" BUTTON & READ RATE ON COUNTER. ACT:________________S/R RAISE INPUT VOLTAGE TO 115V AT 400 CYCLES. READ INPUT CURRENT & METER READING ON TESTER ACT:____________ACT:______________ RAISE VOLTAGE 115V AT 400 CYCLES & PUSH "COUNTER RESET" BUTTON TO READ	✓		
	670 SAME	AFTO FORM 349 COMPLETED & FORWARDED TO DATA AUTOMATION.	M		
	680 650	SAFETY WIRE	M		
	~~690~~ 660	I CERTIFY THAT THIS END ITEM HAS BEEN OVERHAULED IAW T.O., TCTO CURRENT REVISIONS AND SUPPLEMENTS	M		
	700 +	OPERATIONS COMPLETED AND PAPERWORK PROCESSED	M		
	~~710~~ 680	COMPLY WITH MAOI 66-36, PARA 13 TYPE WORK PERFORMED________________	M		